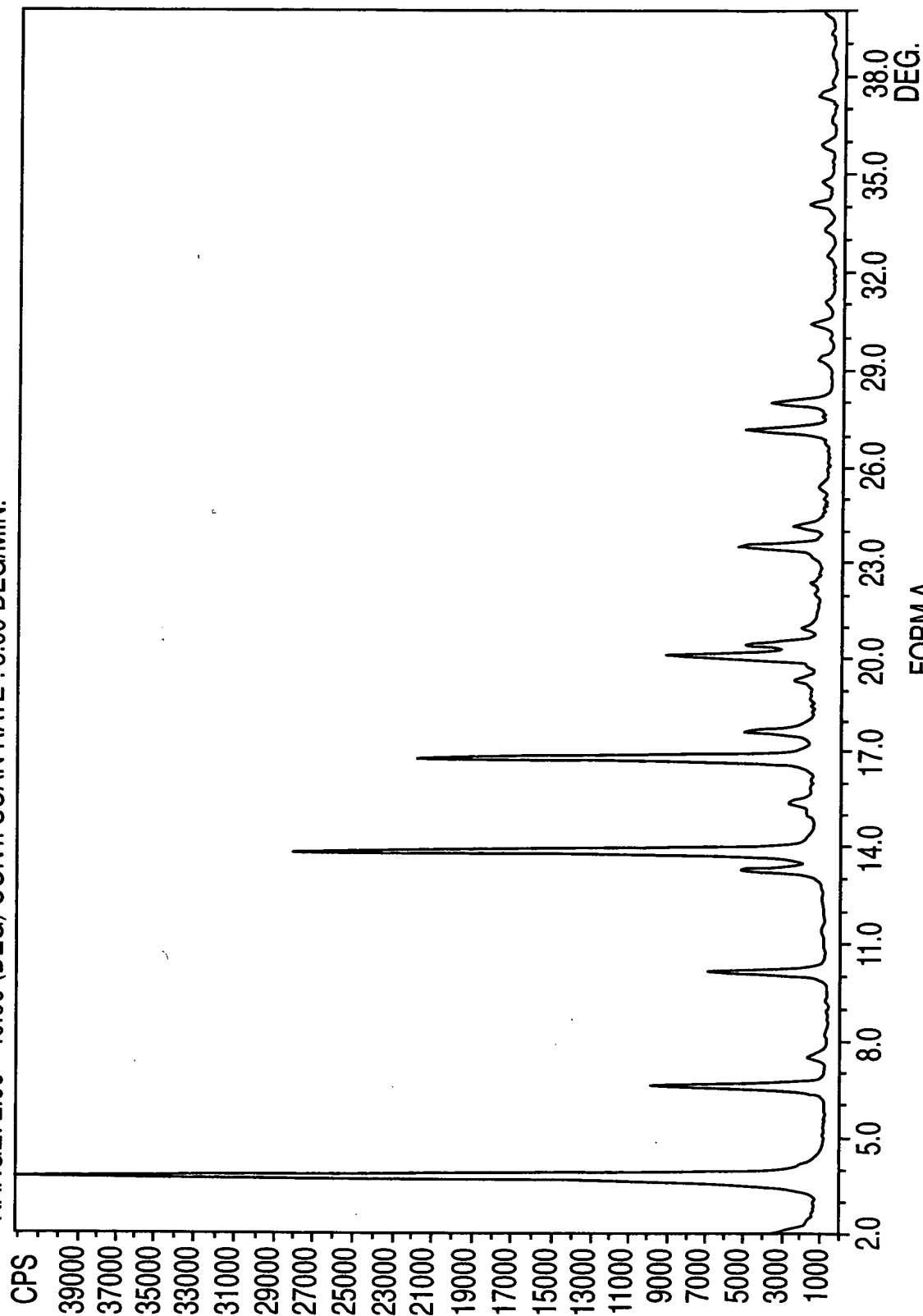




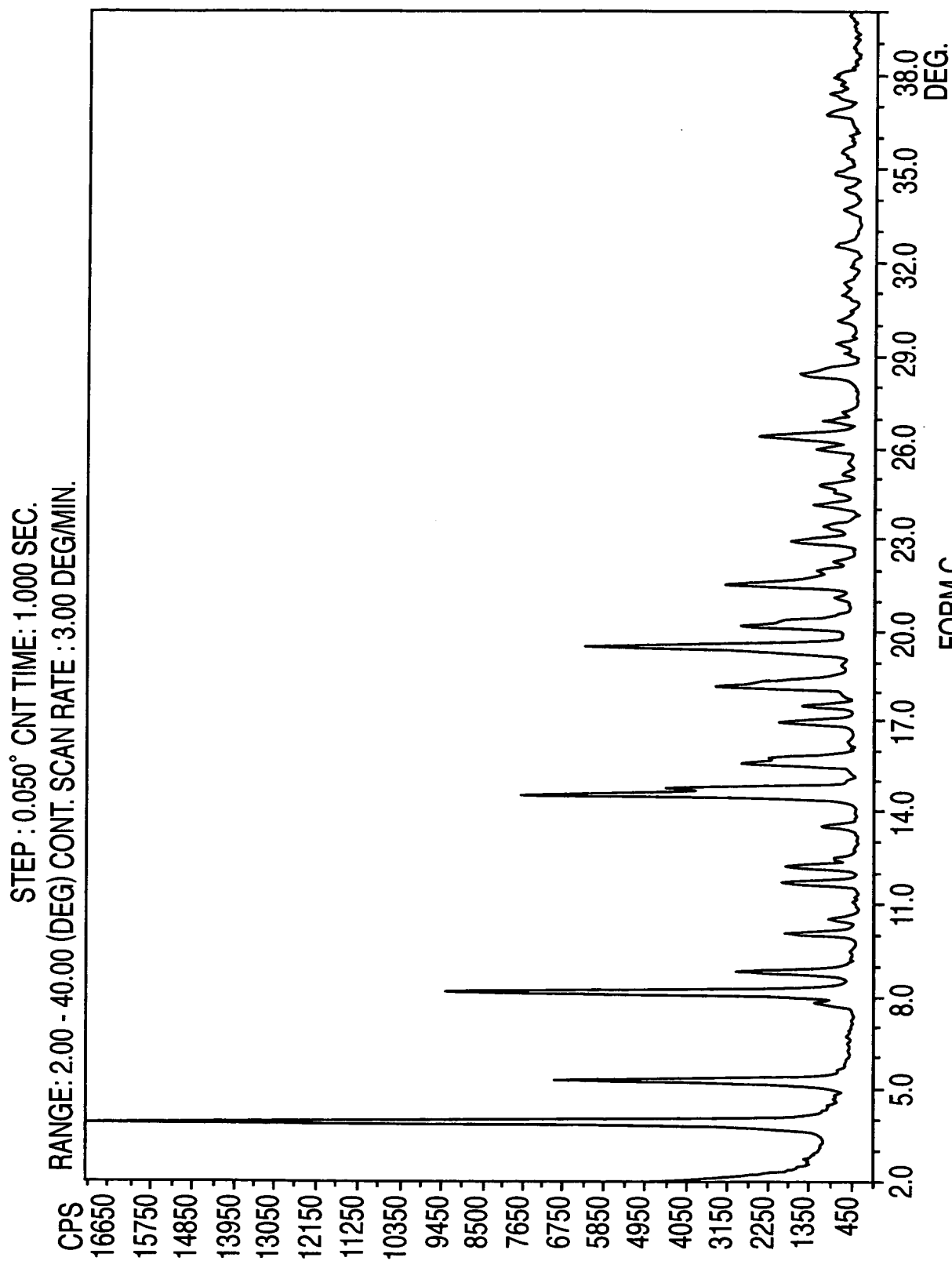
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STEP : 0.050° CNT TIME: 1.000 SEC.
RANGE: 2.00 - 40.00 (DEG) CONT. SCAN RATE : 3.00 DEG/MIN.



FORM A
FIG. 1

⊗



FORM C

FIG. 2

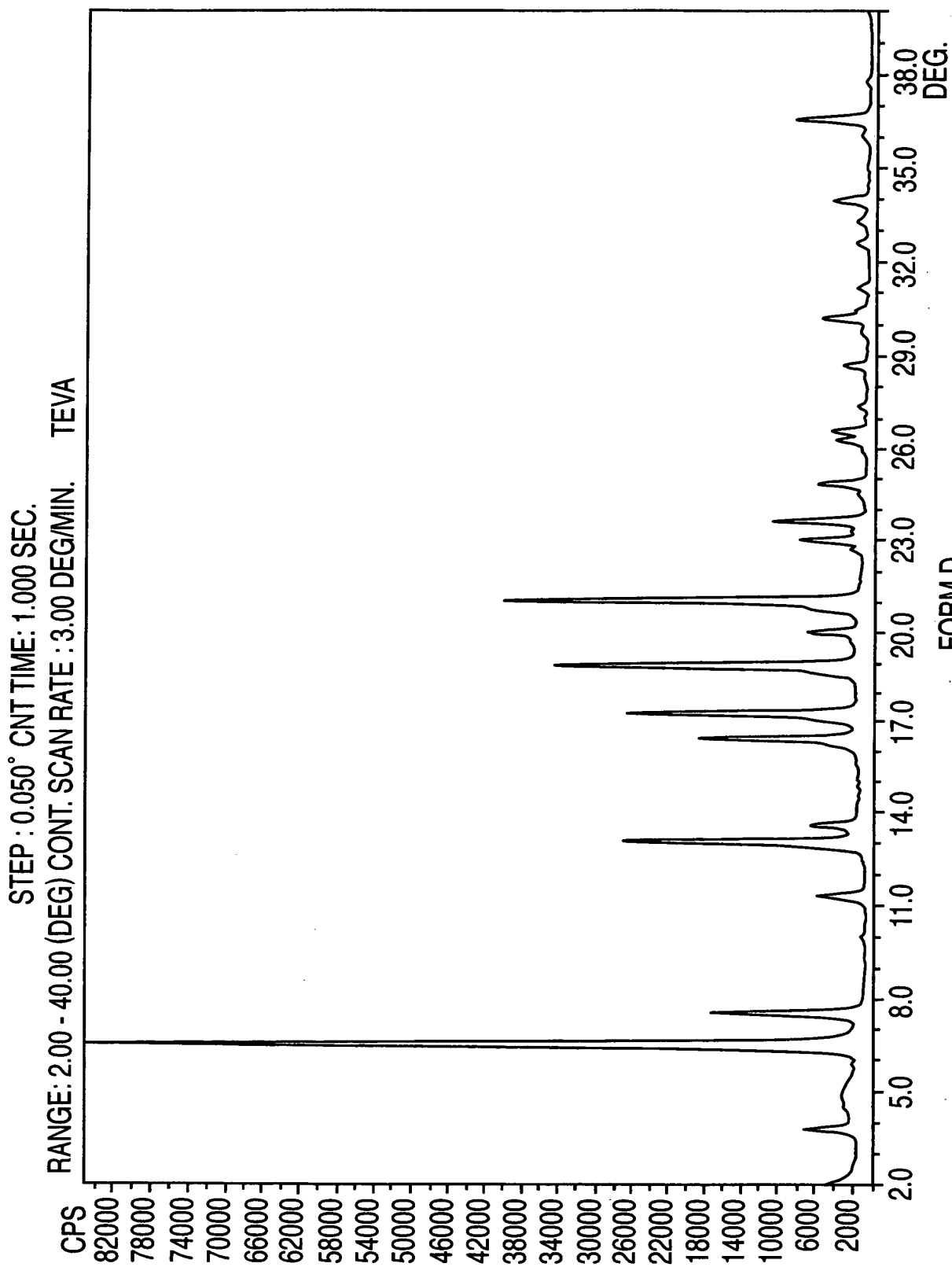
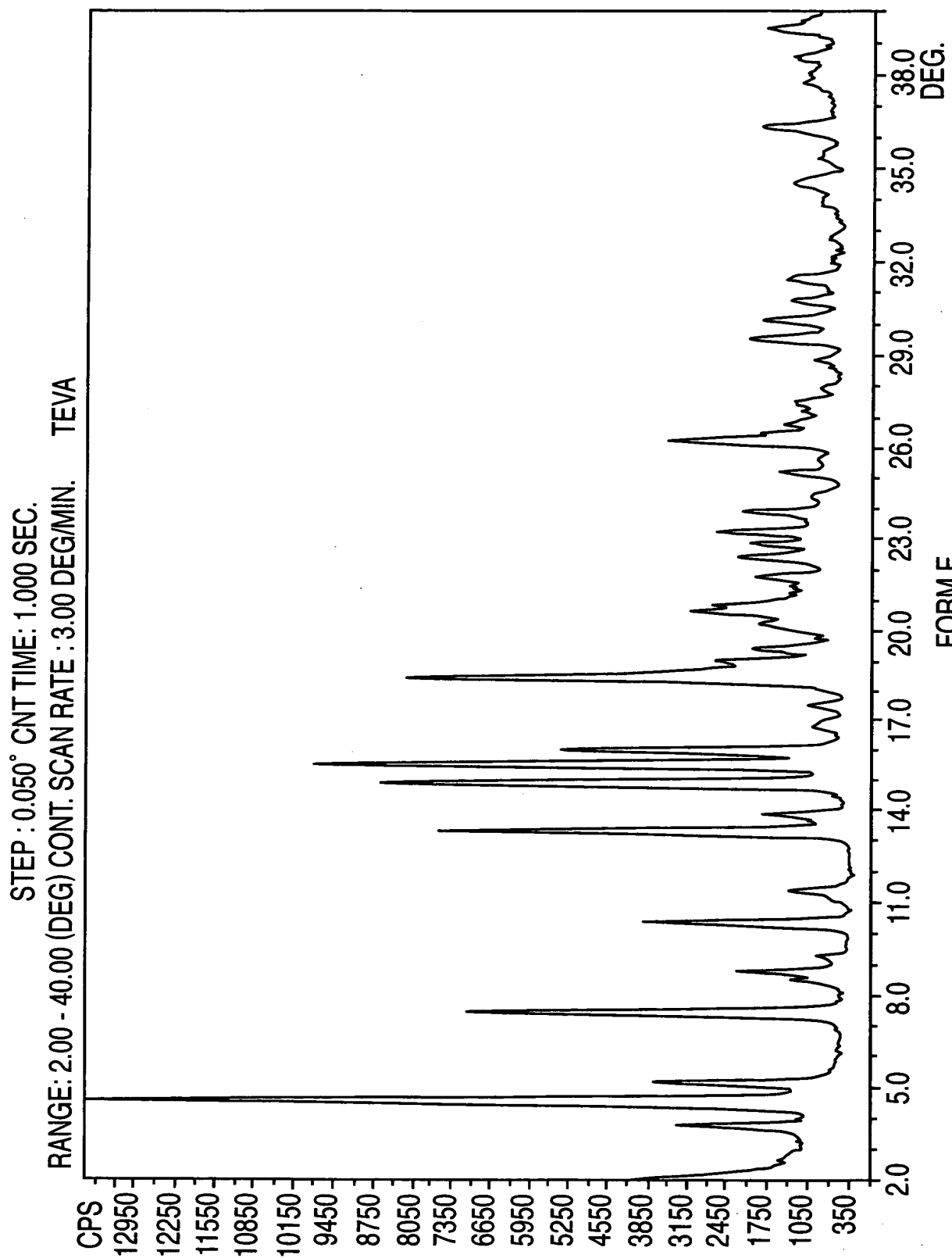
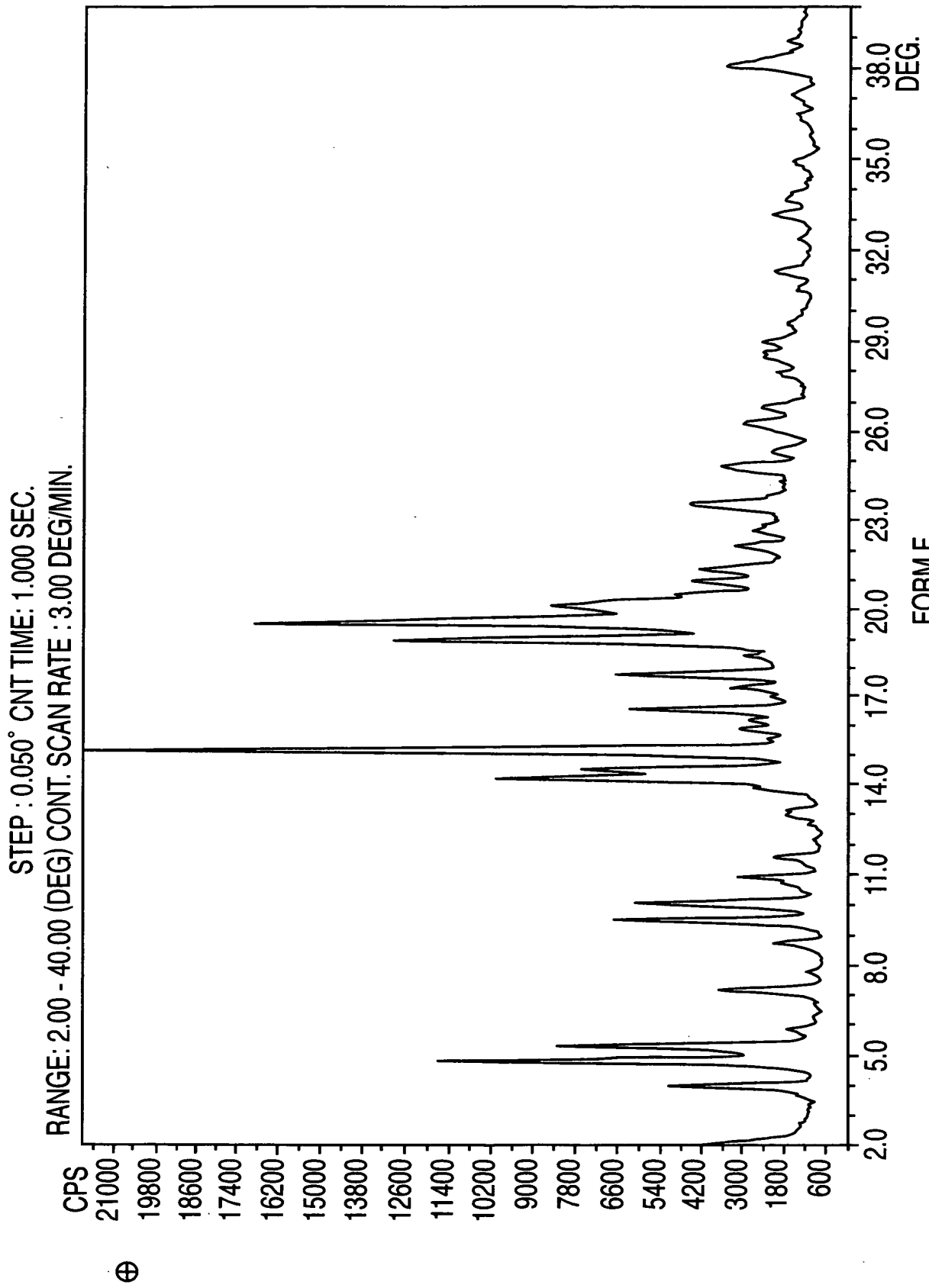


FIG. 3

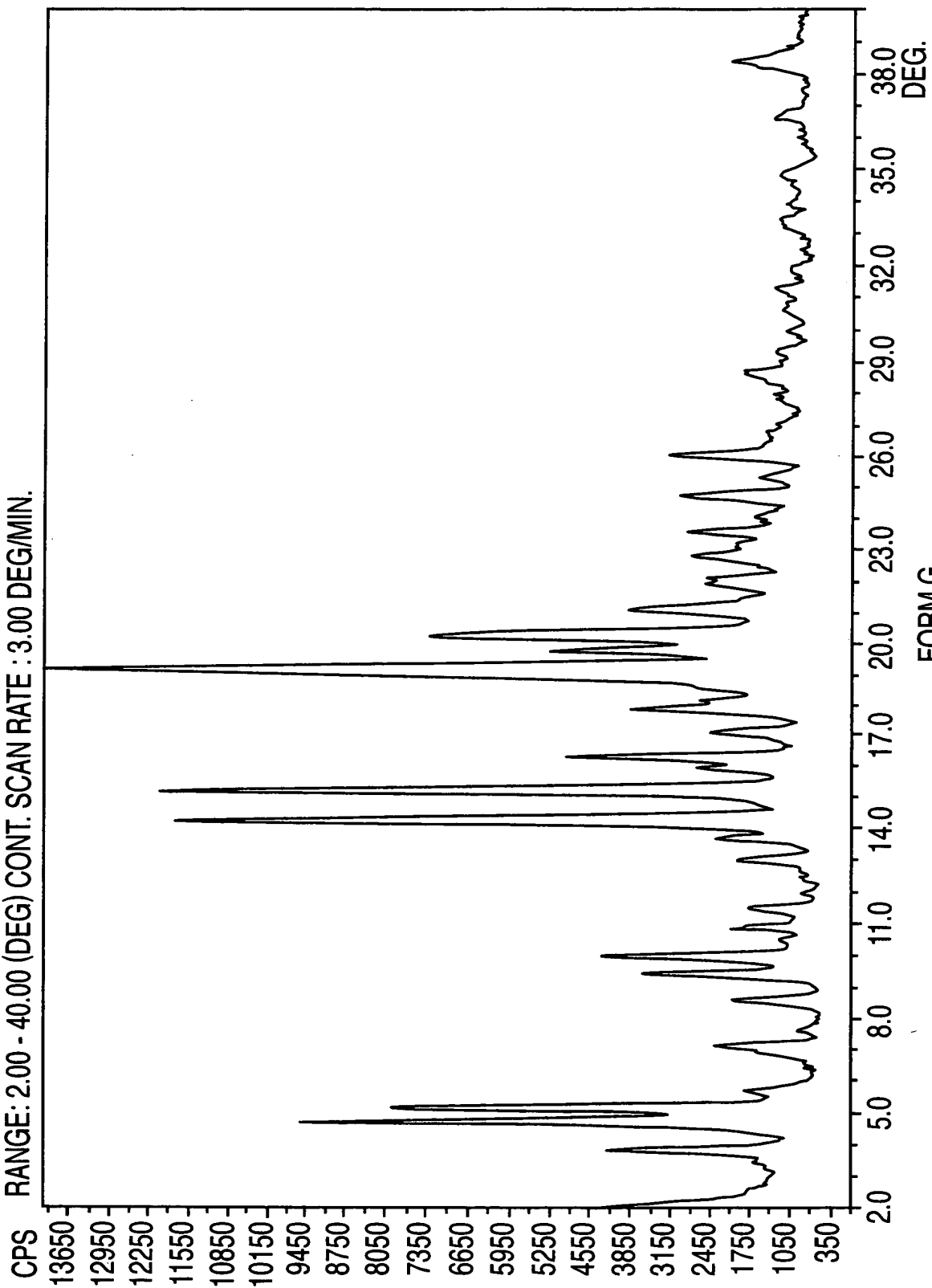


FORME

FIG. 4



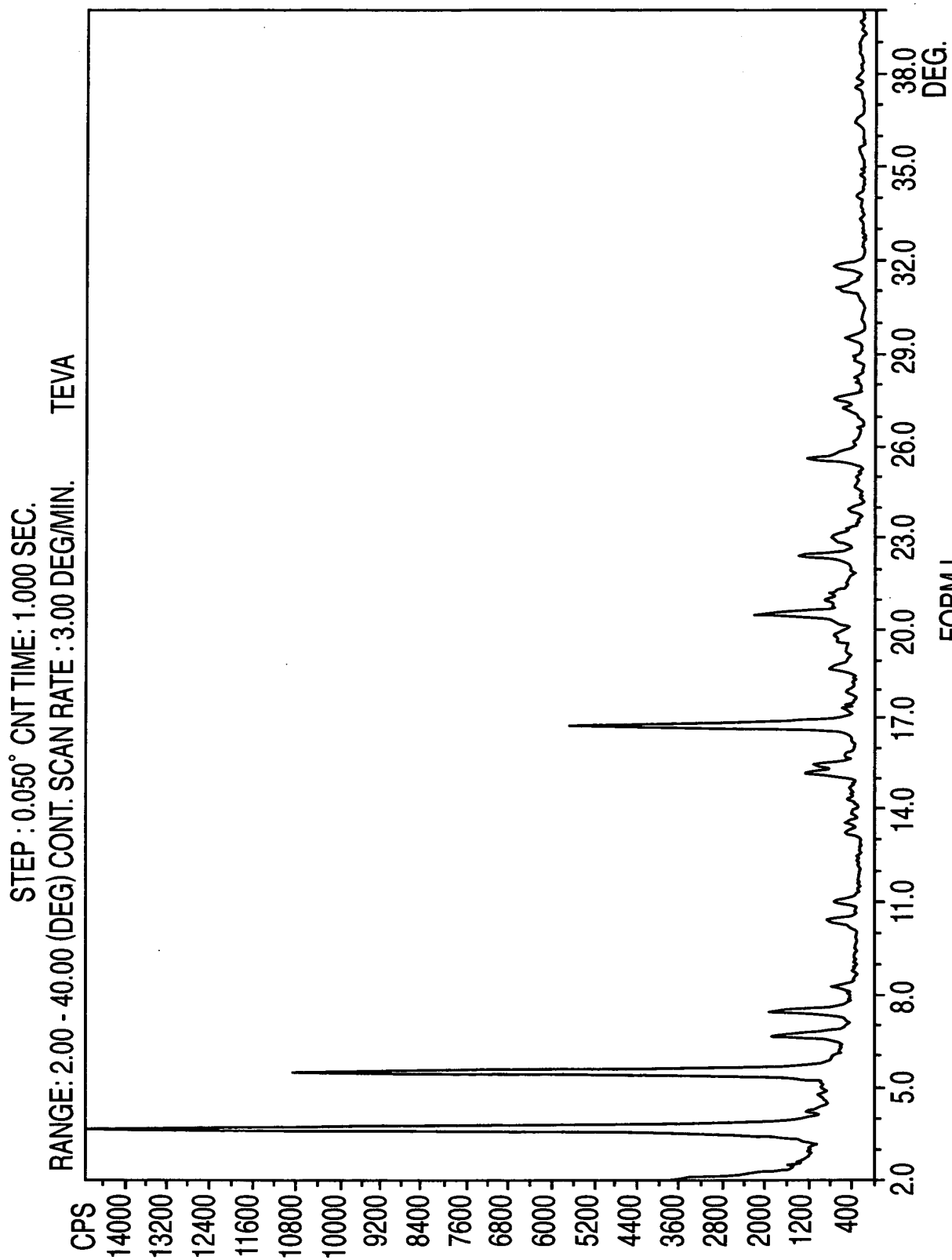
STEP : 0.050° CNT TIME: 1.000 SEC.
RANGE: 2.00 - 40.00 (DEG) CONT. SCAN RATE : 3.00 DEG/MIN.



FORM G

FIG. 6

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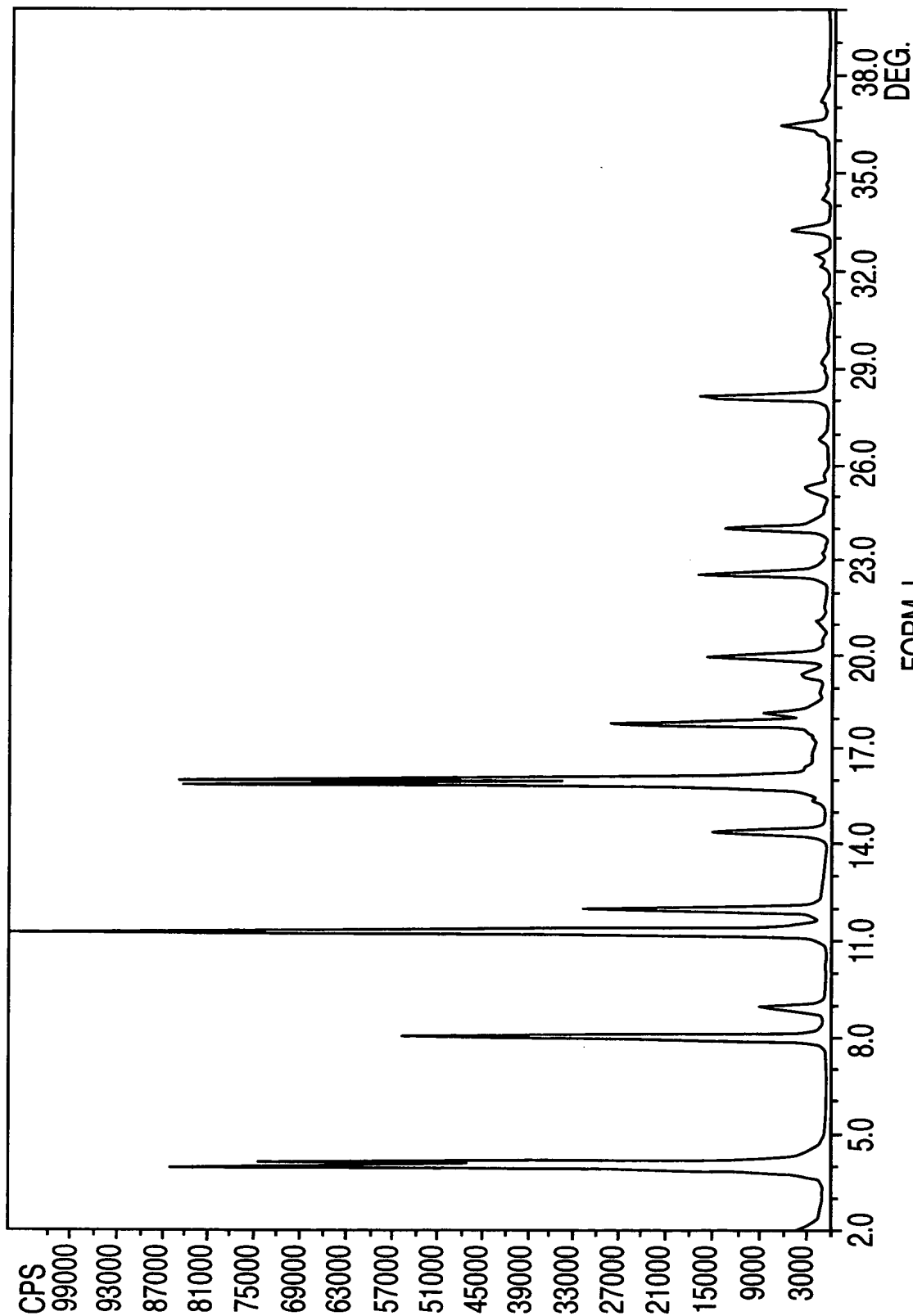
FORM I

FIG. 7

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STEP : 0.050° CNT TIME: 1.000 SEC.

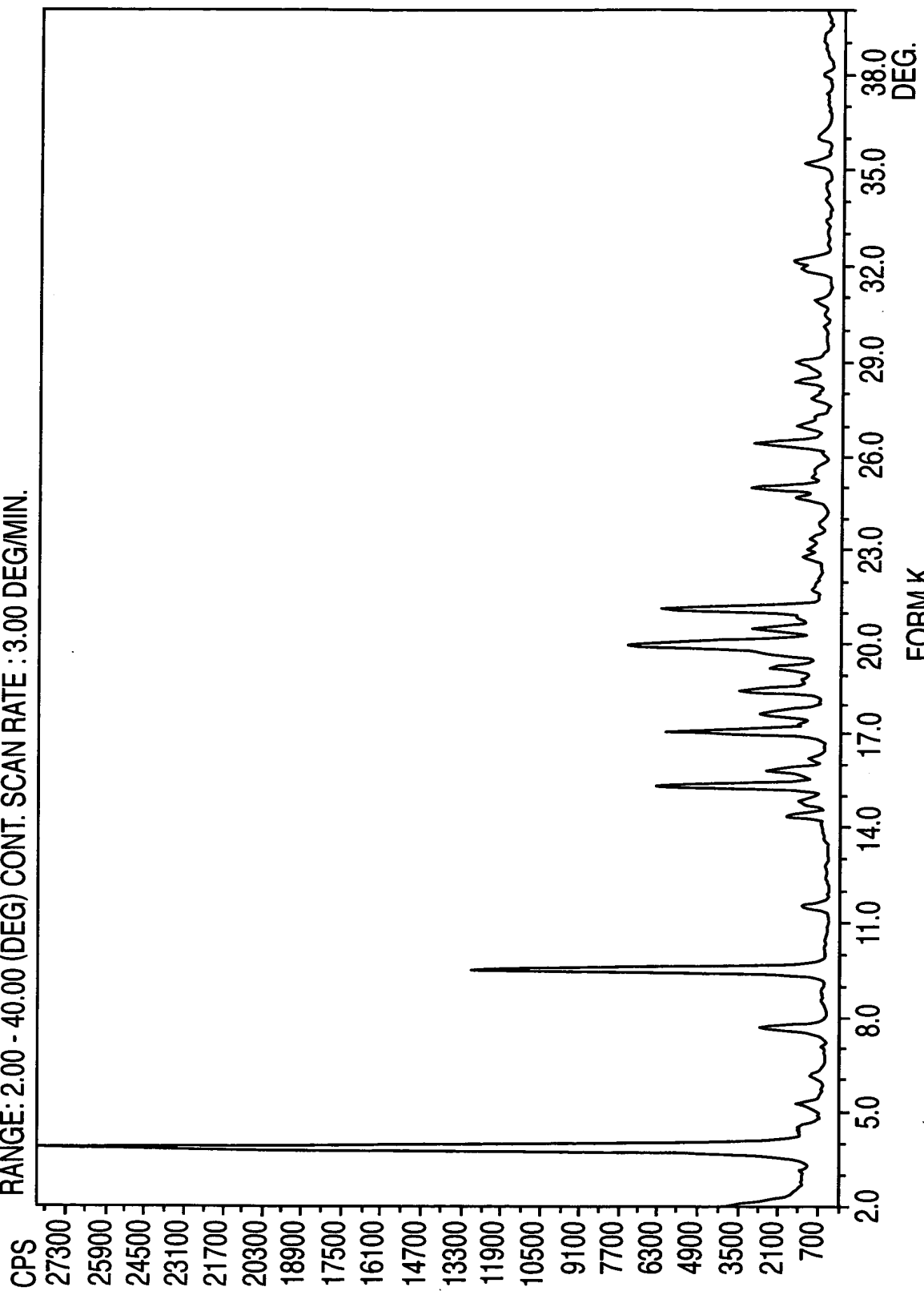
RANGE: 2.00 - 40.00 (DEG) CONT. SCAN RATE : 3.00 DEG/MIN.



FORM J

FIG. 8

STEP : 0.050° CNT TIME: 1.000 SEC.
RANGE: 2.00 - 40.00 (DEG) CONT. SCAN RATE : 3.00 DEG/MIN.



FORM K

FIG. 9

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STEP : 0.050° CNT TIME: 1.000 SEC.
RANGE: 2.00 - 40.00 (DEG) CONT. SCAN RATE : 3.00 DEG/MIN.

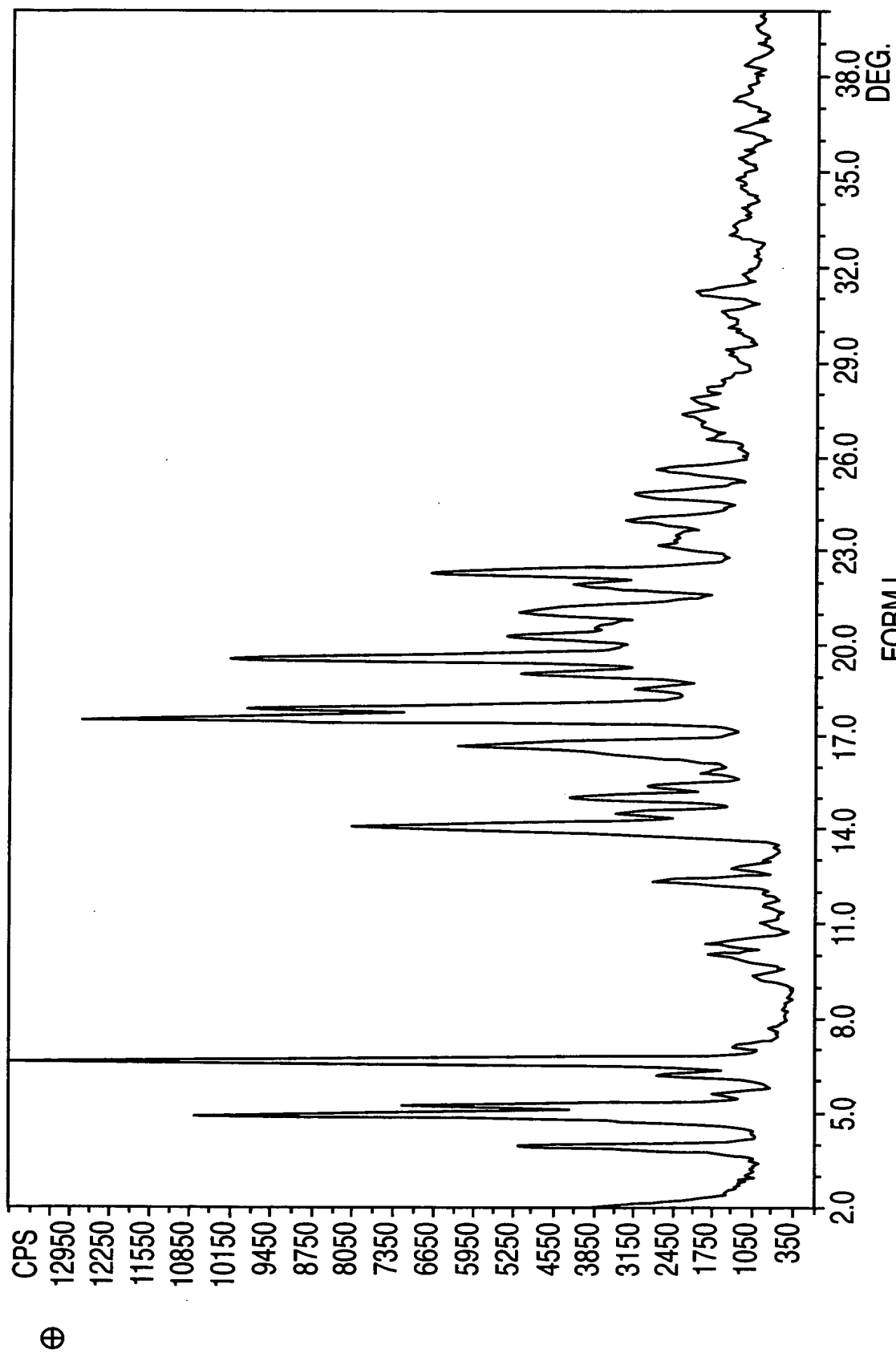
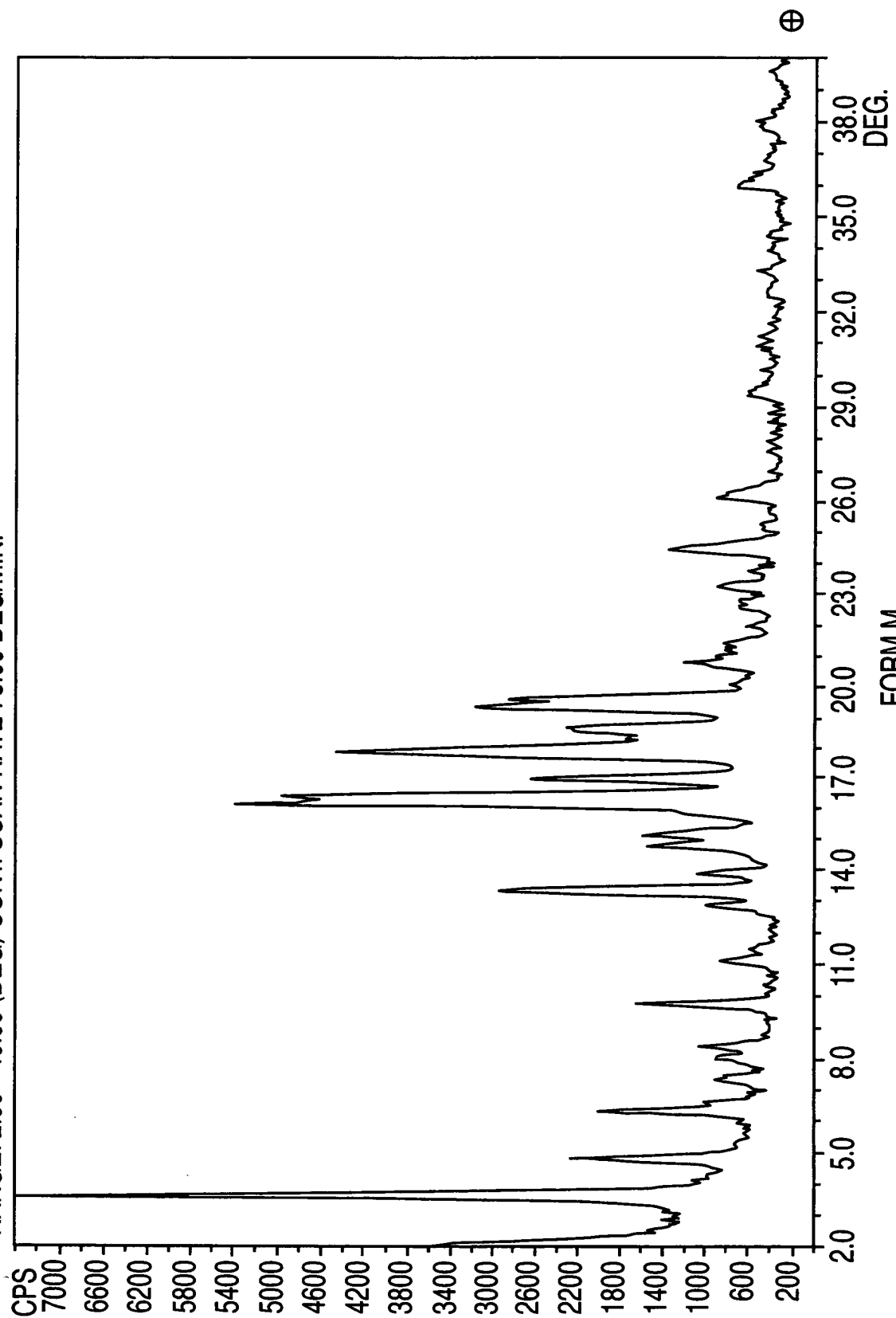


FIG. 10

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STEP : 0.050° CNT TIME: 1.000 SEC.
RANGE: 2.00 - 40.00 (DEG) CONT. SCAN RATE : 3.00 DEG/MIN.



FORM M

FIG. 11

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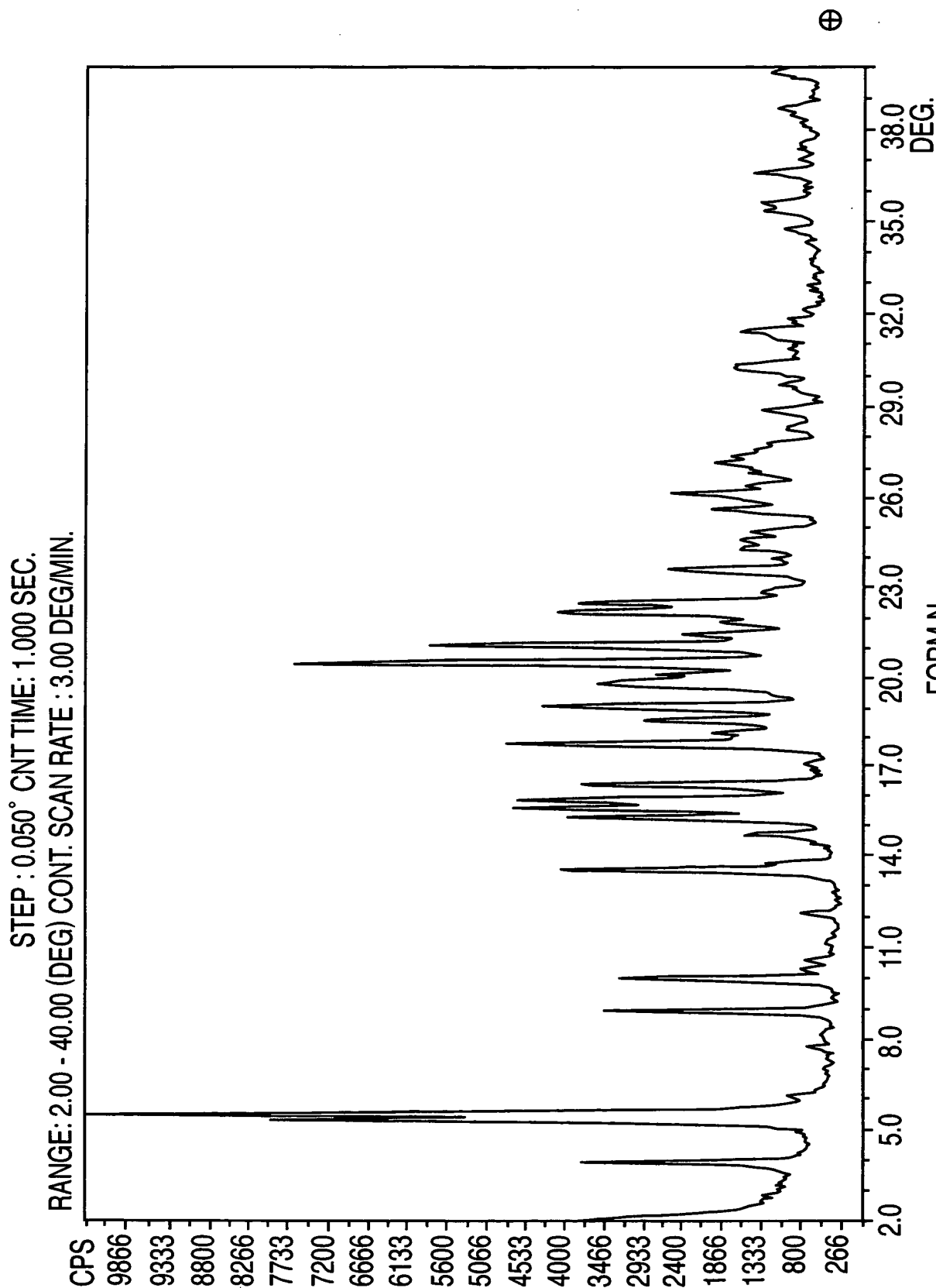
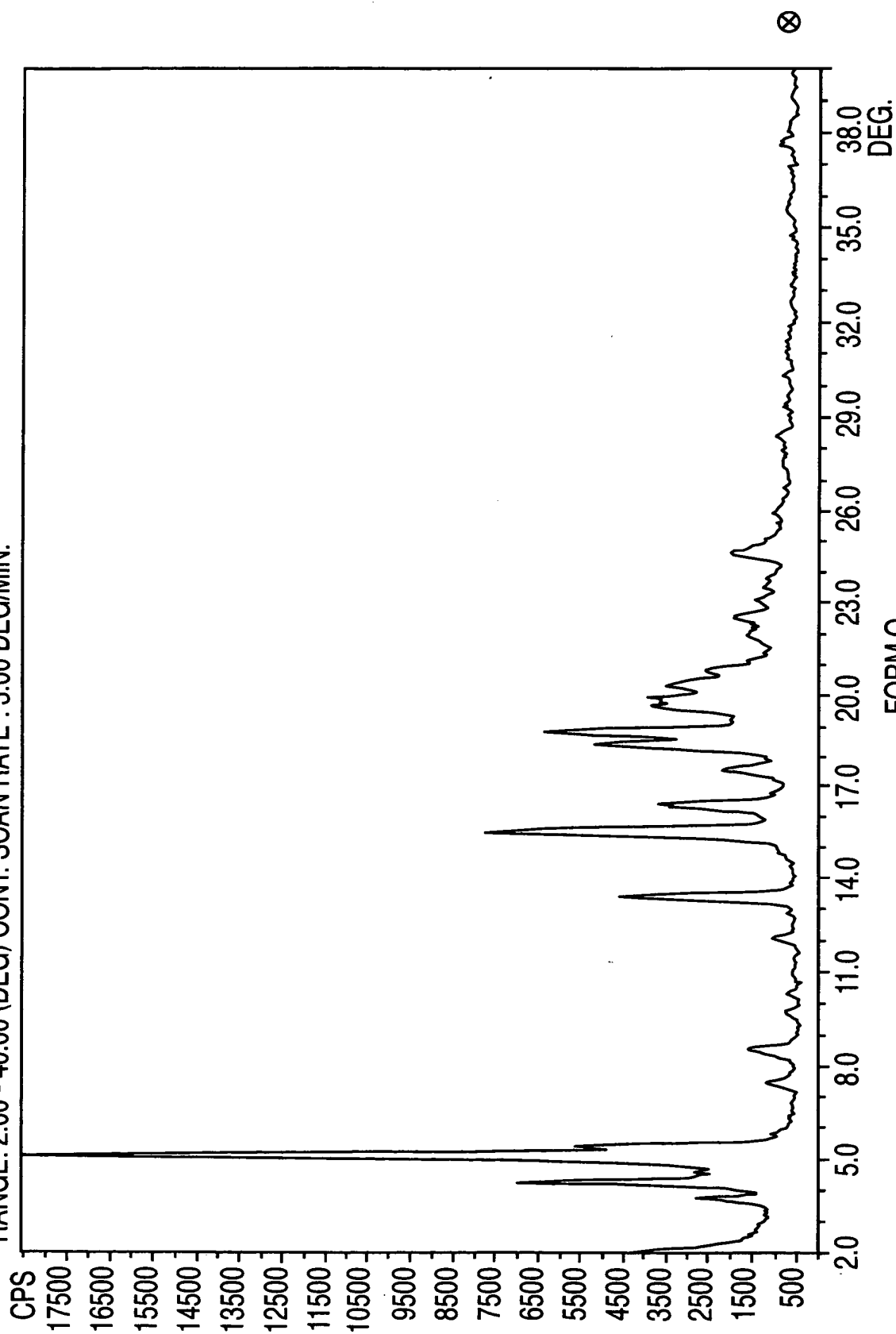


FIG. 12

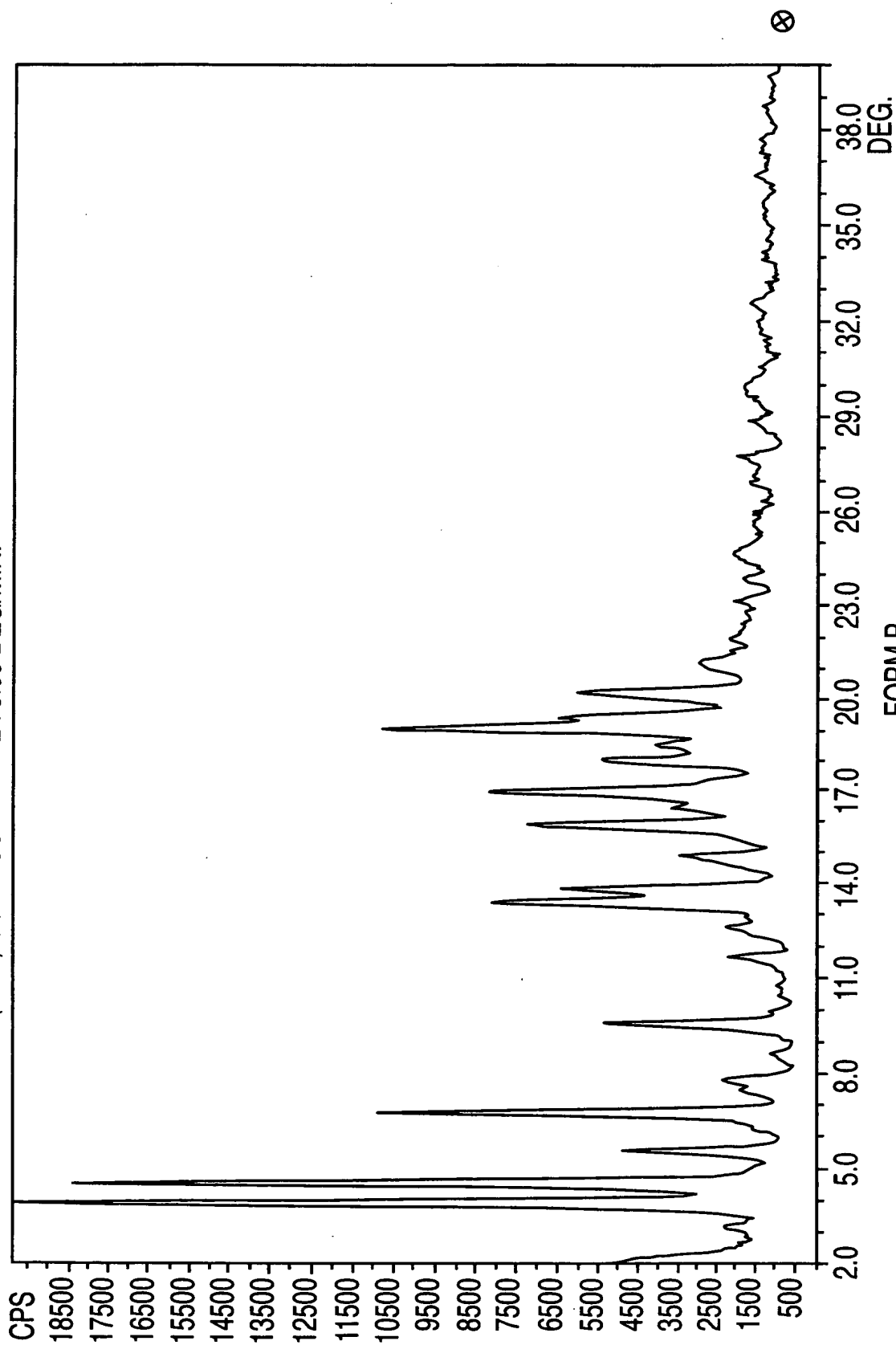
STEP : 0.050° CNT TIME: 1.000 SEC.
RANGE: 2.00 - 40.00 (DEG) CONT. SCAN RATE : 3.00 DEG/MIN.



FORMO
FIG. 13

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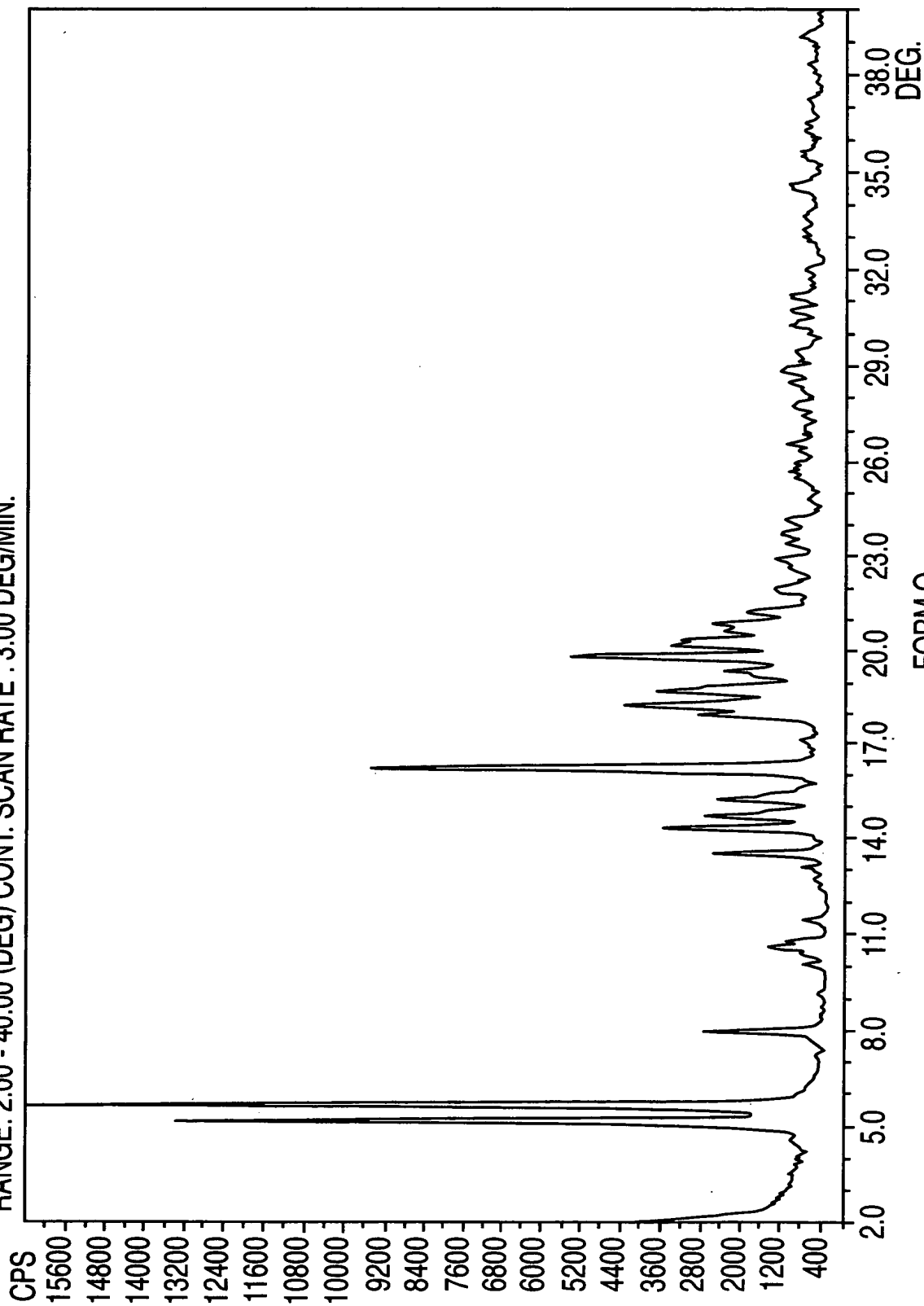
STEP : 0.050° CNT TIME: 1.000 SEC.
RANGE: 2.00 - 40.00 (DEG) CONT. SCAN RATE : 3.00 DEG/MIN.



FORM P

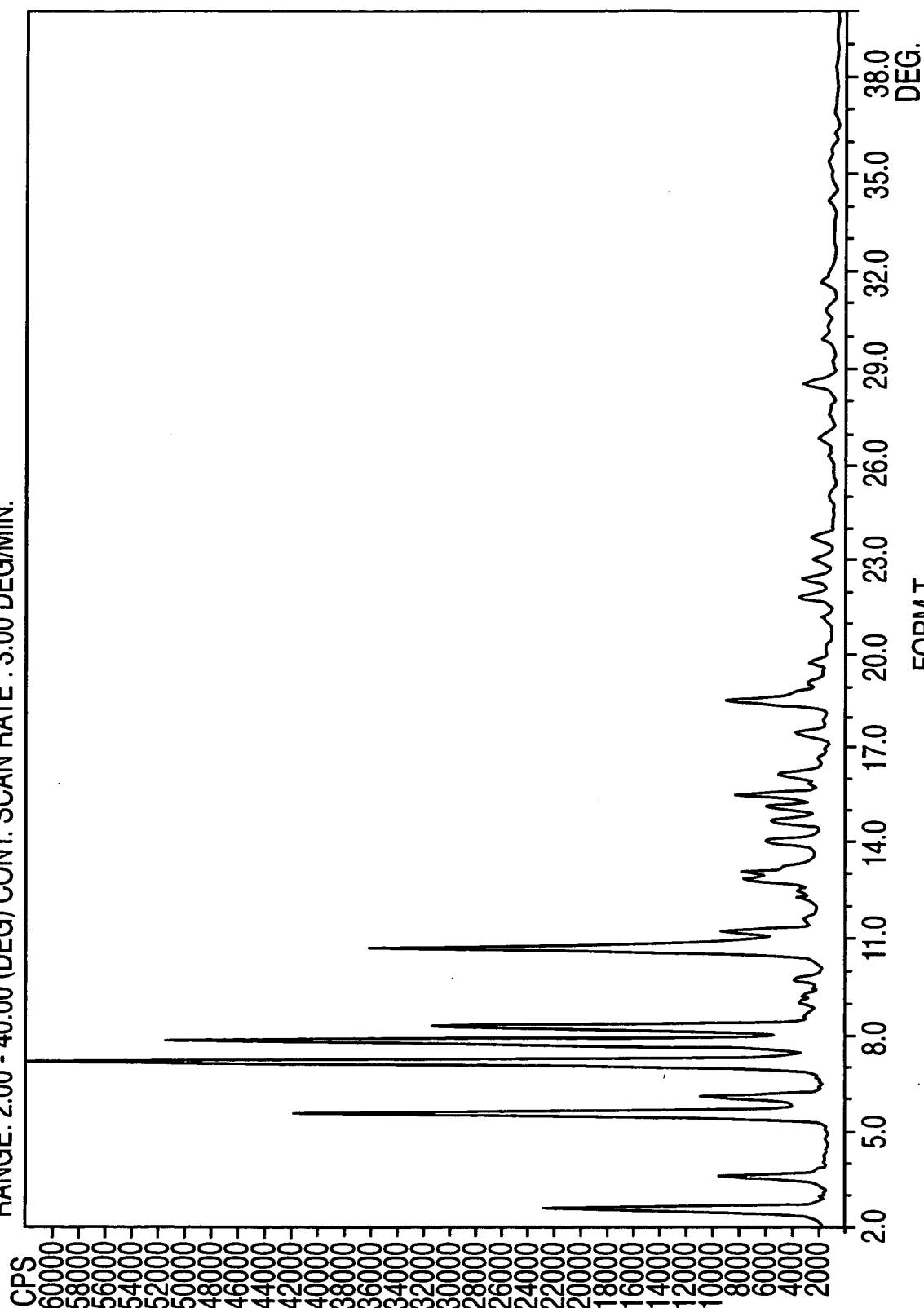
FIG. 14

STEP : 0.050° CNT TIME: 1.000 SEC.
RANGE: 2.00 - 40.00 (DEG) CONT. SCAN RATE : 3.00 DEG/MIN.



FORM Q
FIG. 15

STEP : 0.050° CNT TIME: 1.000 SEC.
RANGE: 2.00 - 40.00 (DEG) CONT. SCAN RATE : 3.00 DEG/MIN.

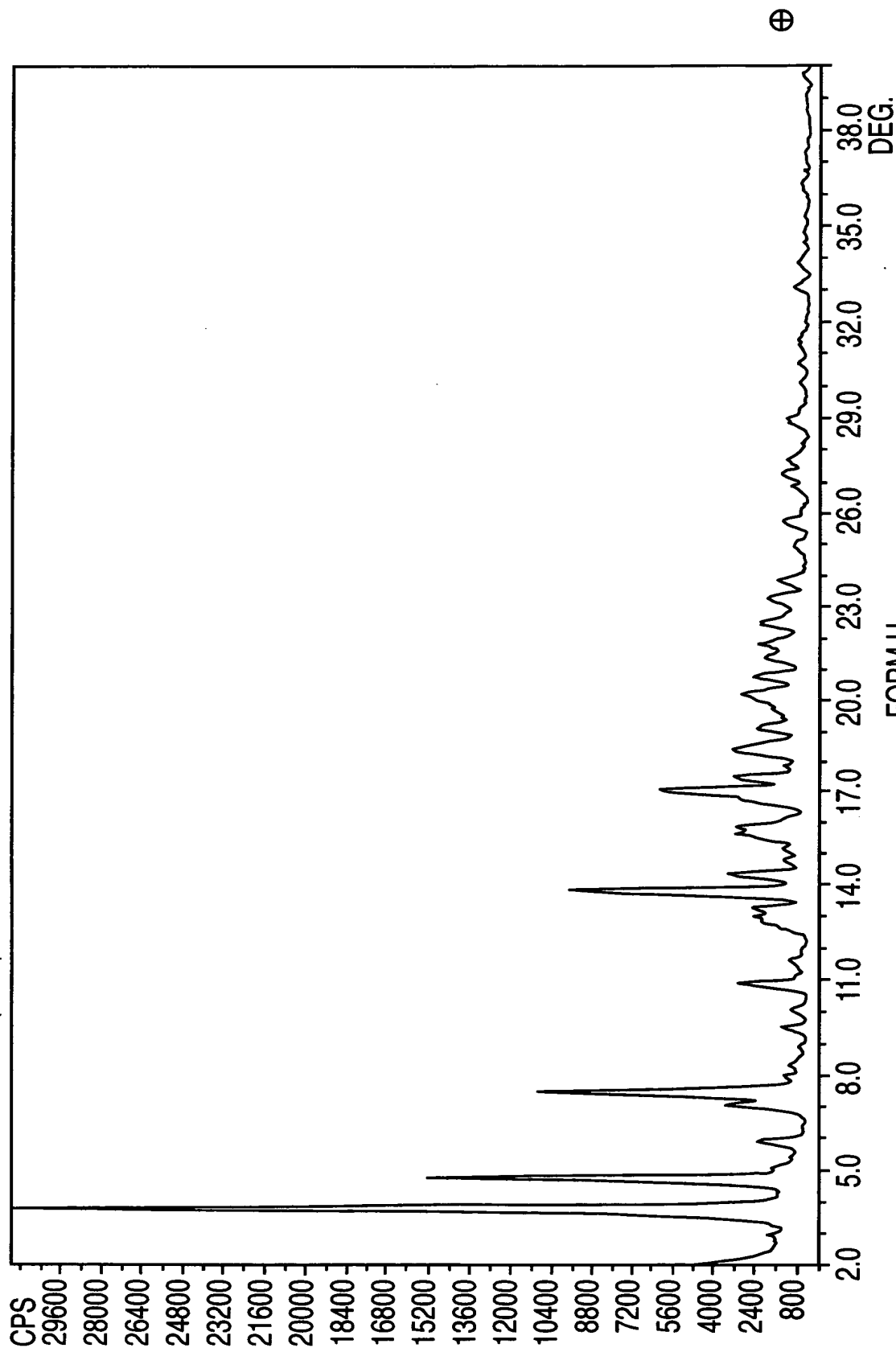


FORM T

FIG. 16

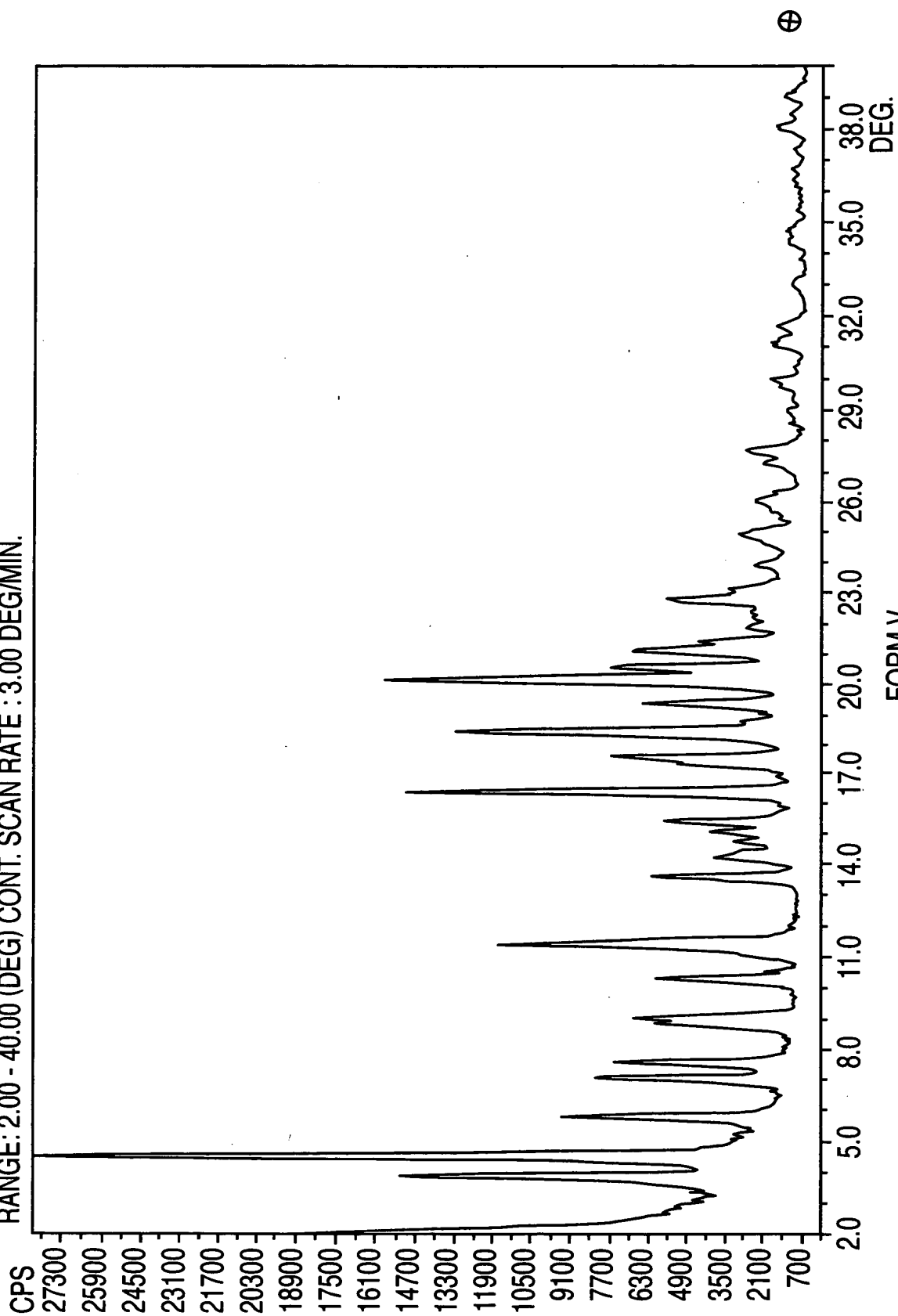
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STEP : 0.050° CNT TIME: 1.000 SEC.
RANGE: 2.00 - 40.00 (DEG) CONT. SCAN RATE : 3.00 DEG/MIN.



FORM U
FIG. 17

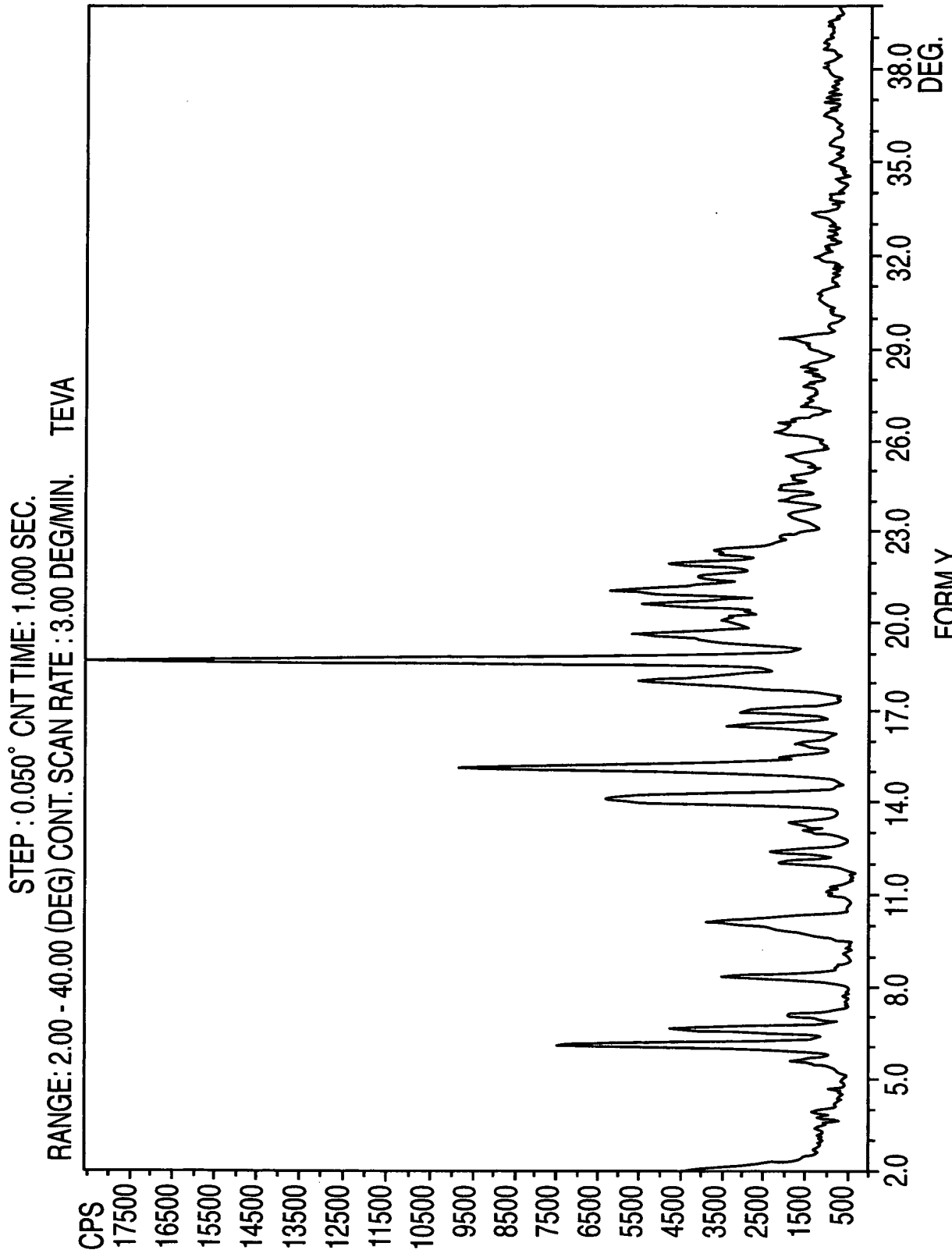
STEP : 0.050° CNT TIME: 1.000 SEC.
RANGE: 2.00 - 40.00 (DEG) CONT. SCAN RATE : 3.00 DEG/MIN.



FORM V

FIG. 18

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FORM Y

FIG. 19

STEP : 0.050° CNT TIME : 1.000 SEC.
RANGE : 2.00 - 40.00 (DEG) CONT. SCAN RATE : 3.00 DEG/MIN.

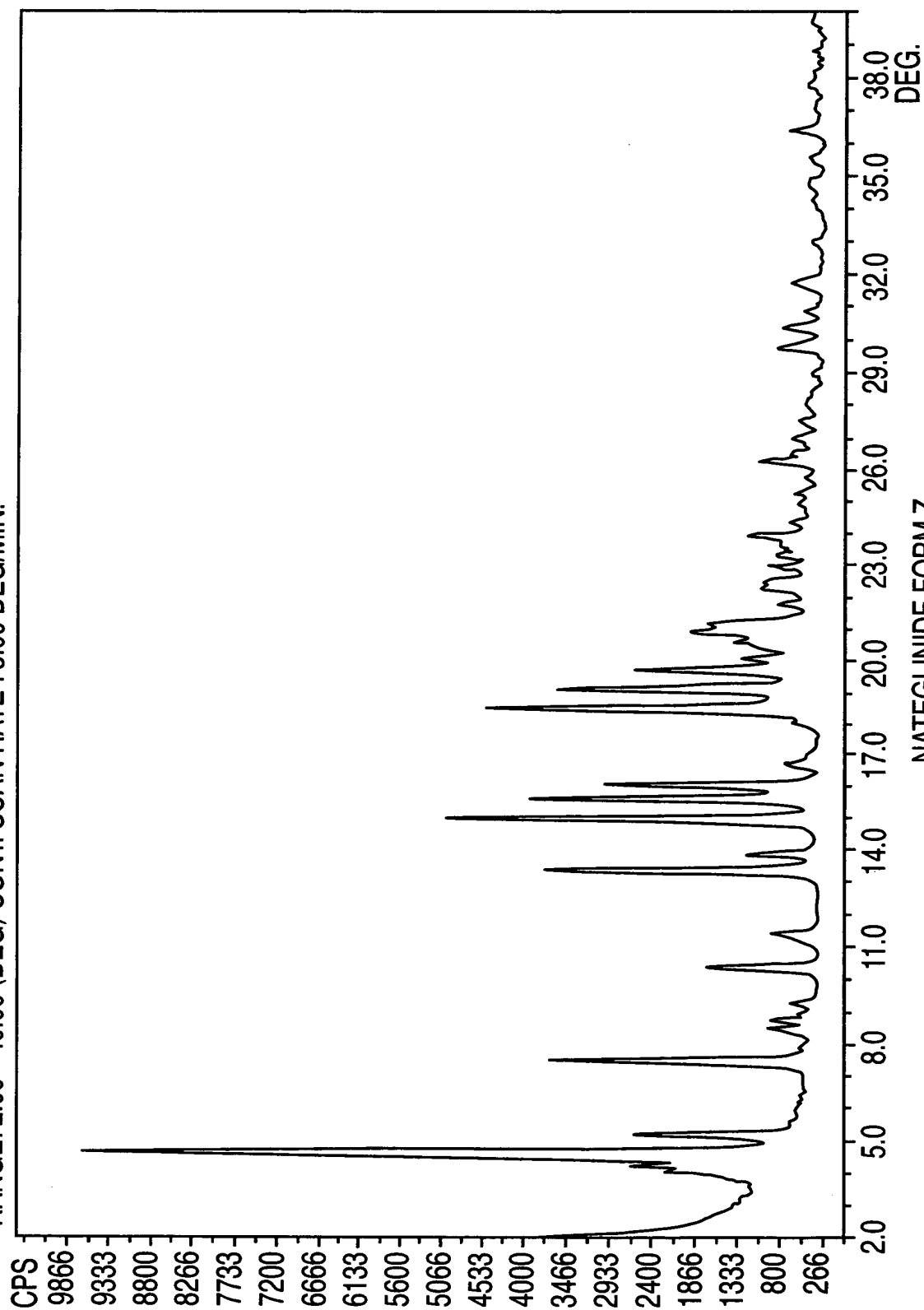
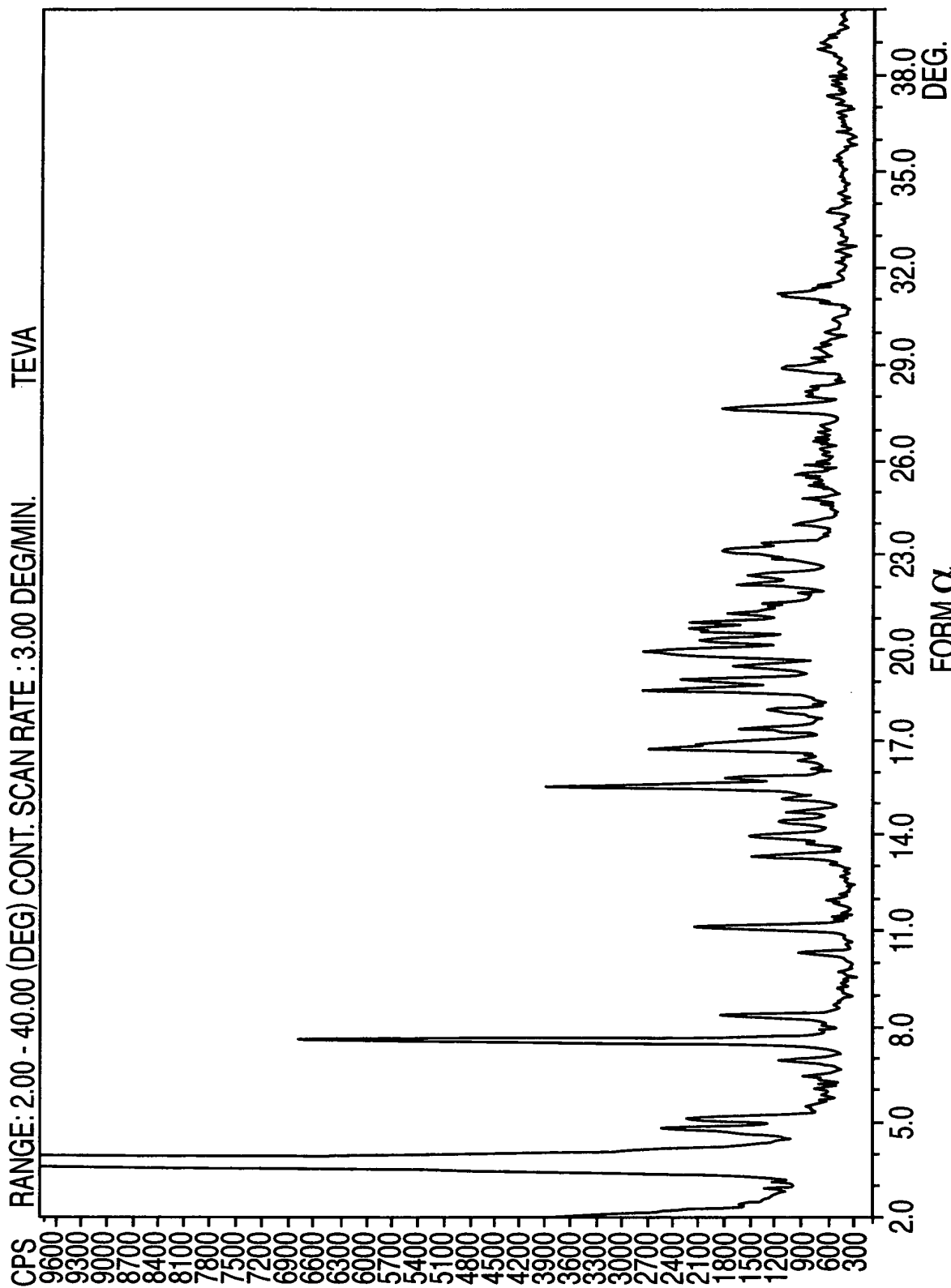


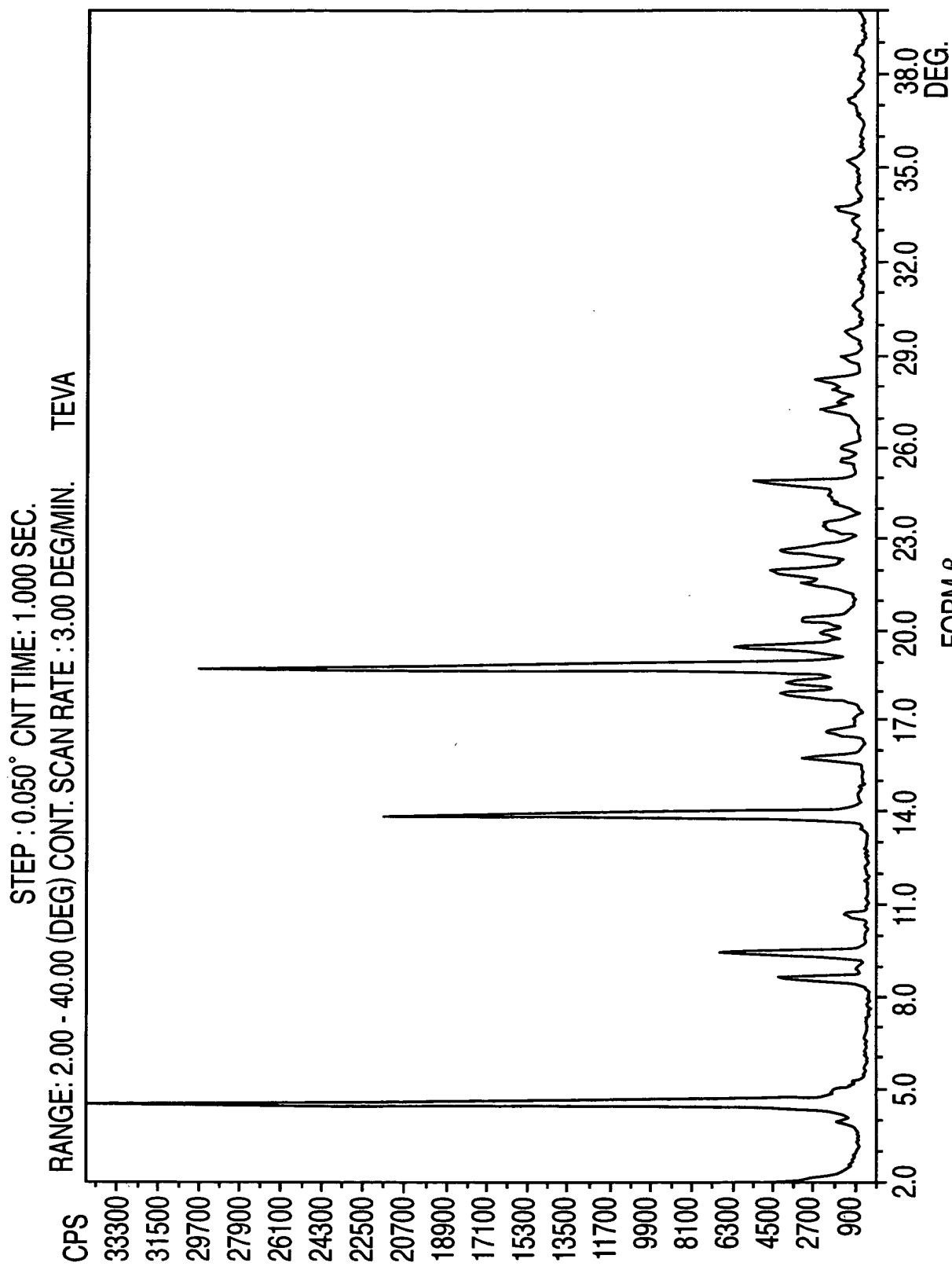
FIG. 20

STEP : 0.050° CNT TIME: 1.000 SEC.
RANGE: 2.00 - 40.00 (DEG) CONT. SCAN RATE : 3.00 DEG/MIN. TEVA



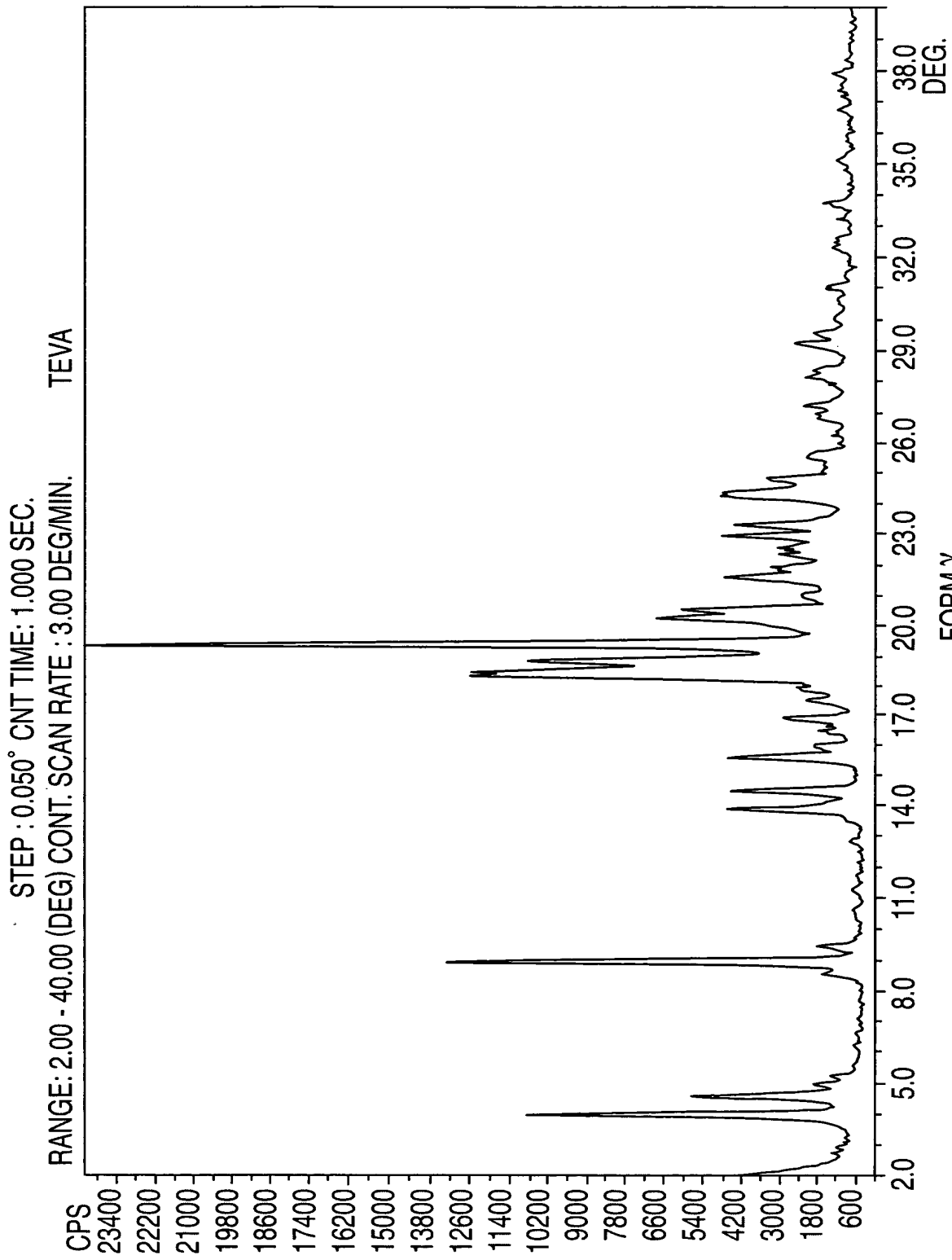
FORM A

FIG. 21

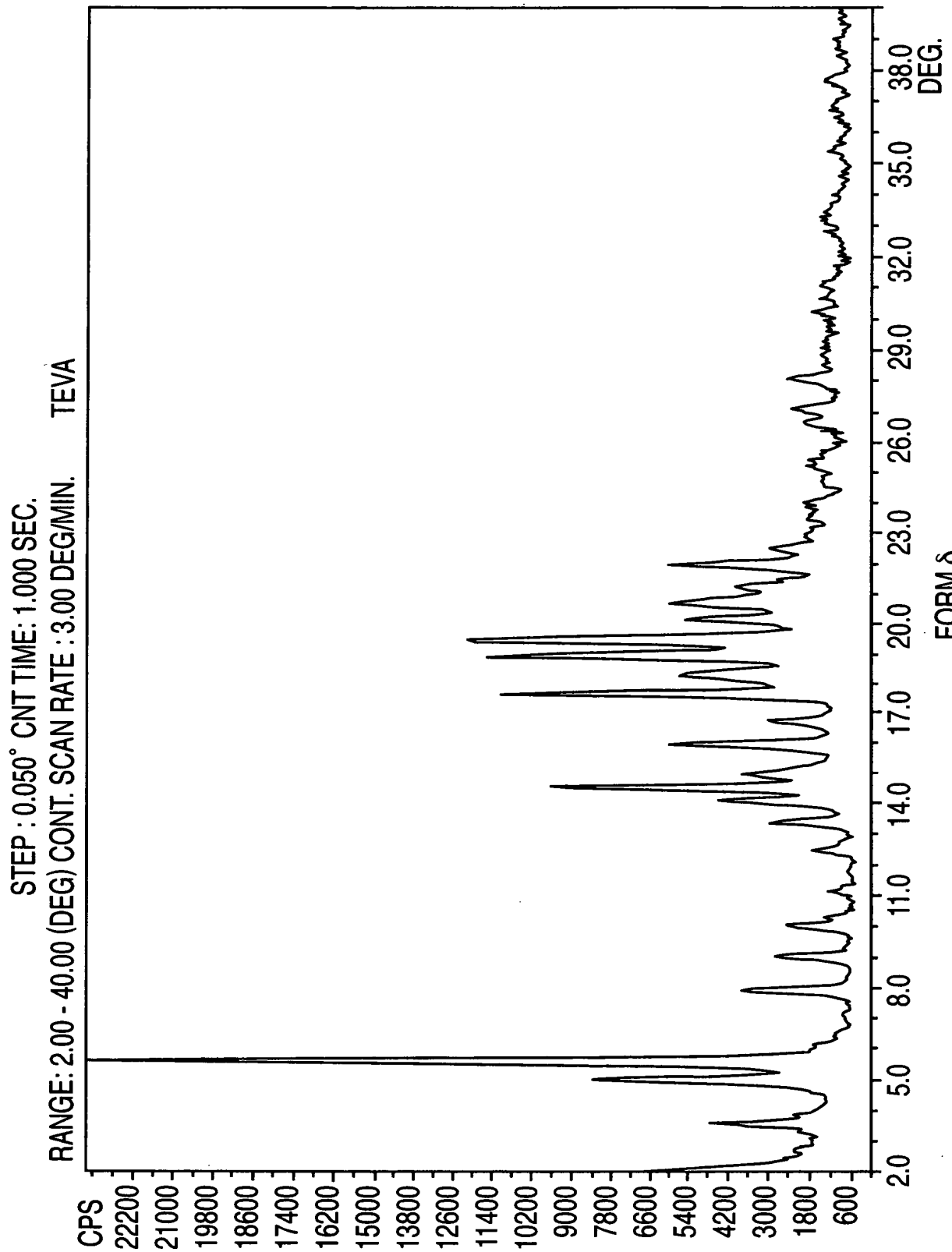


FORM β

FIG. 22



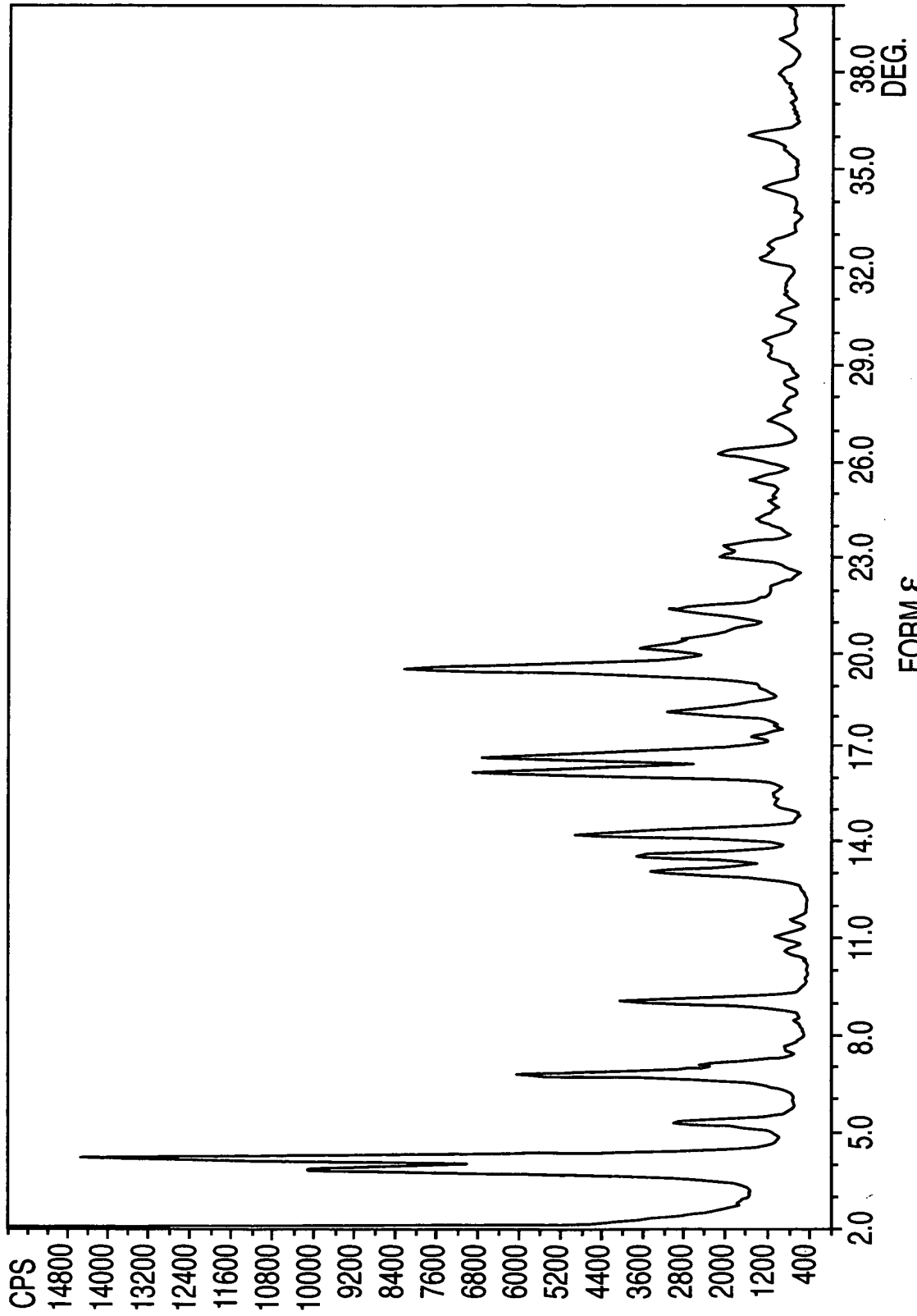
FORM Y
FIG. 23



FORM 8

FIG. 24

STEP : 0.050° CNT TIME: 1.000 SEC.
RANGE: 2.00 - 40.00 (DEG) CONT. SCAN RATE : 3.00 DEG/MIN. TEVA



FORM E
FIG. 25

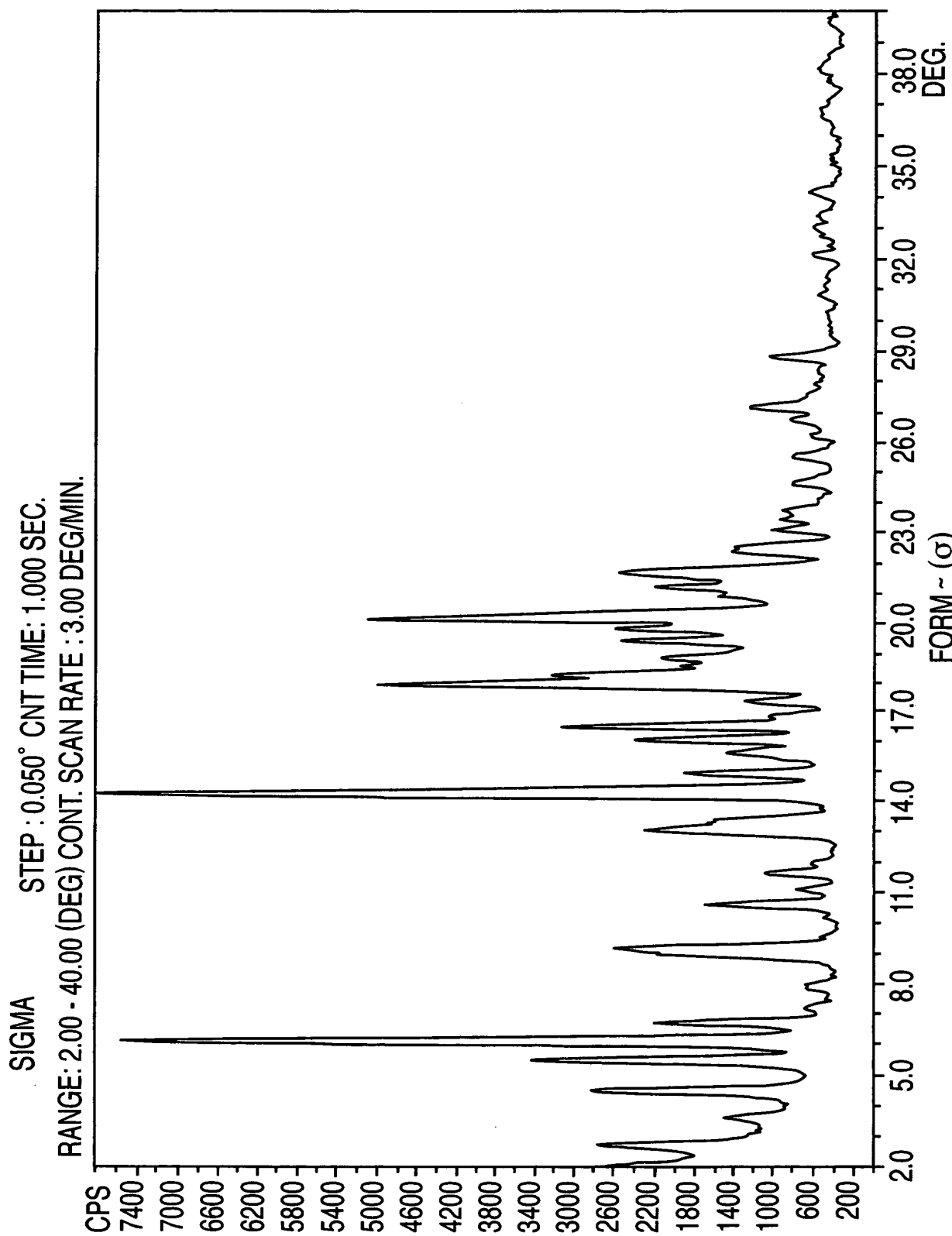


FIG. 26

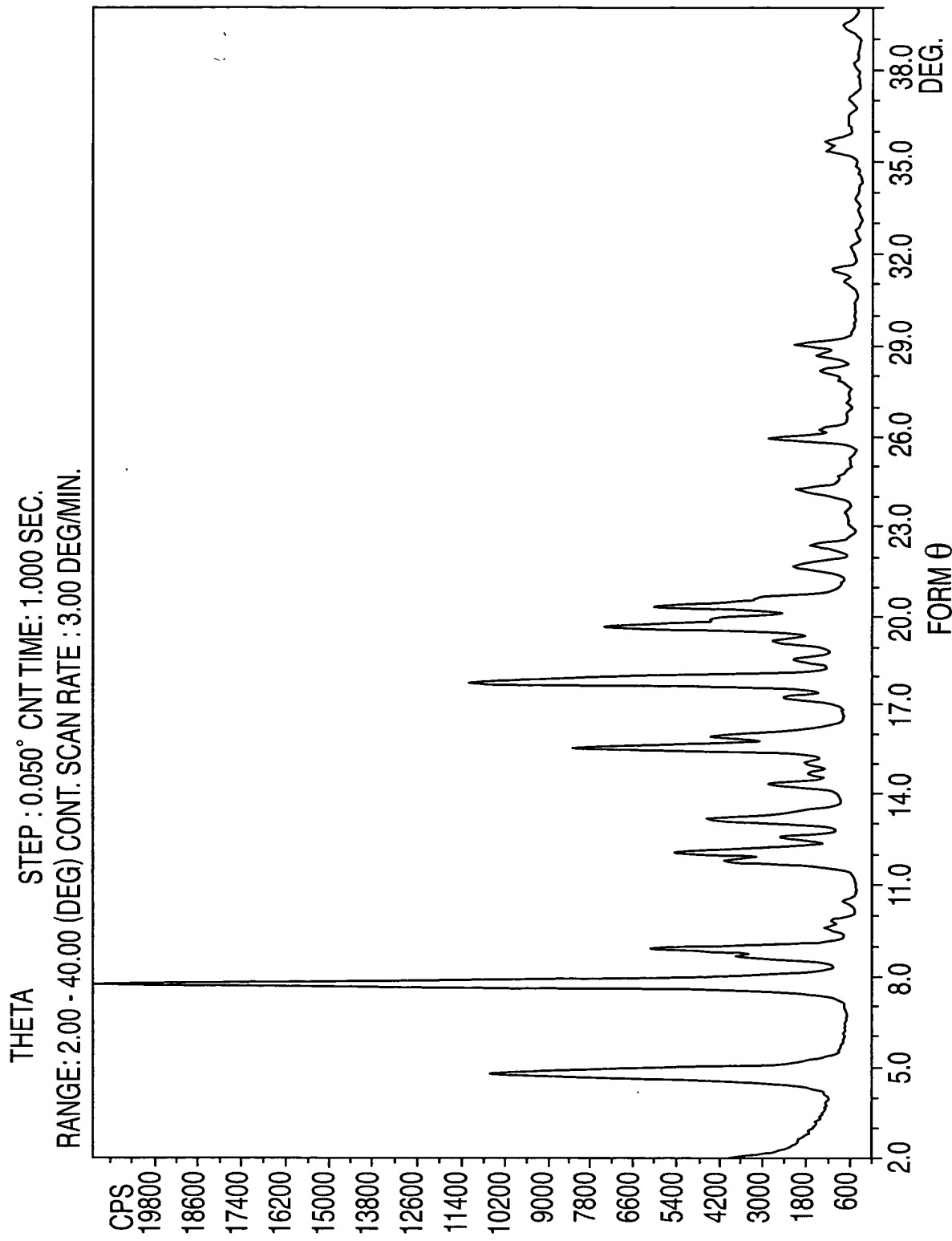


FIG. 27

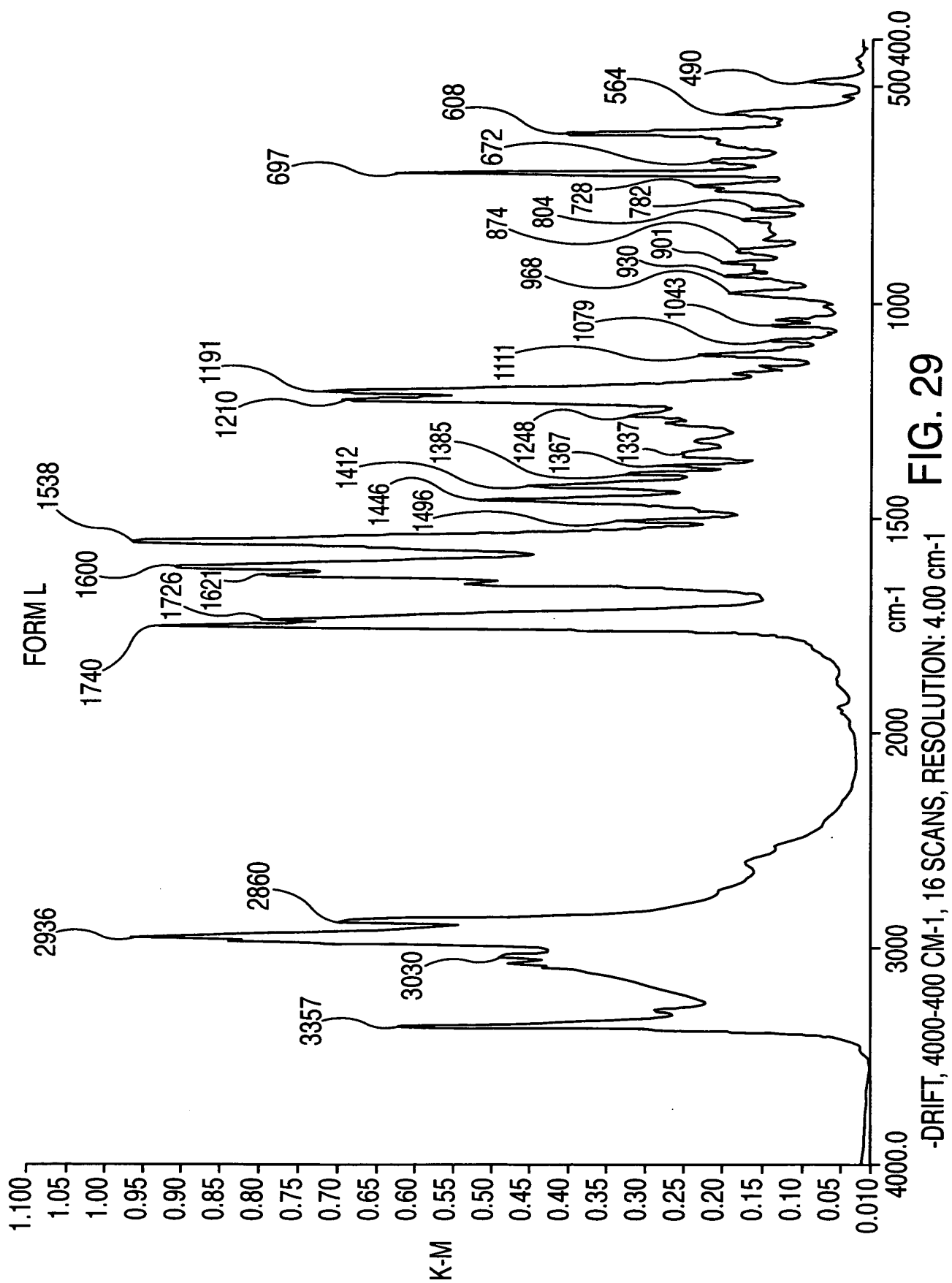


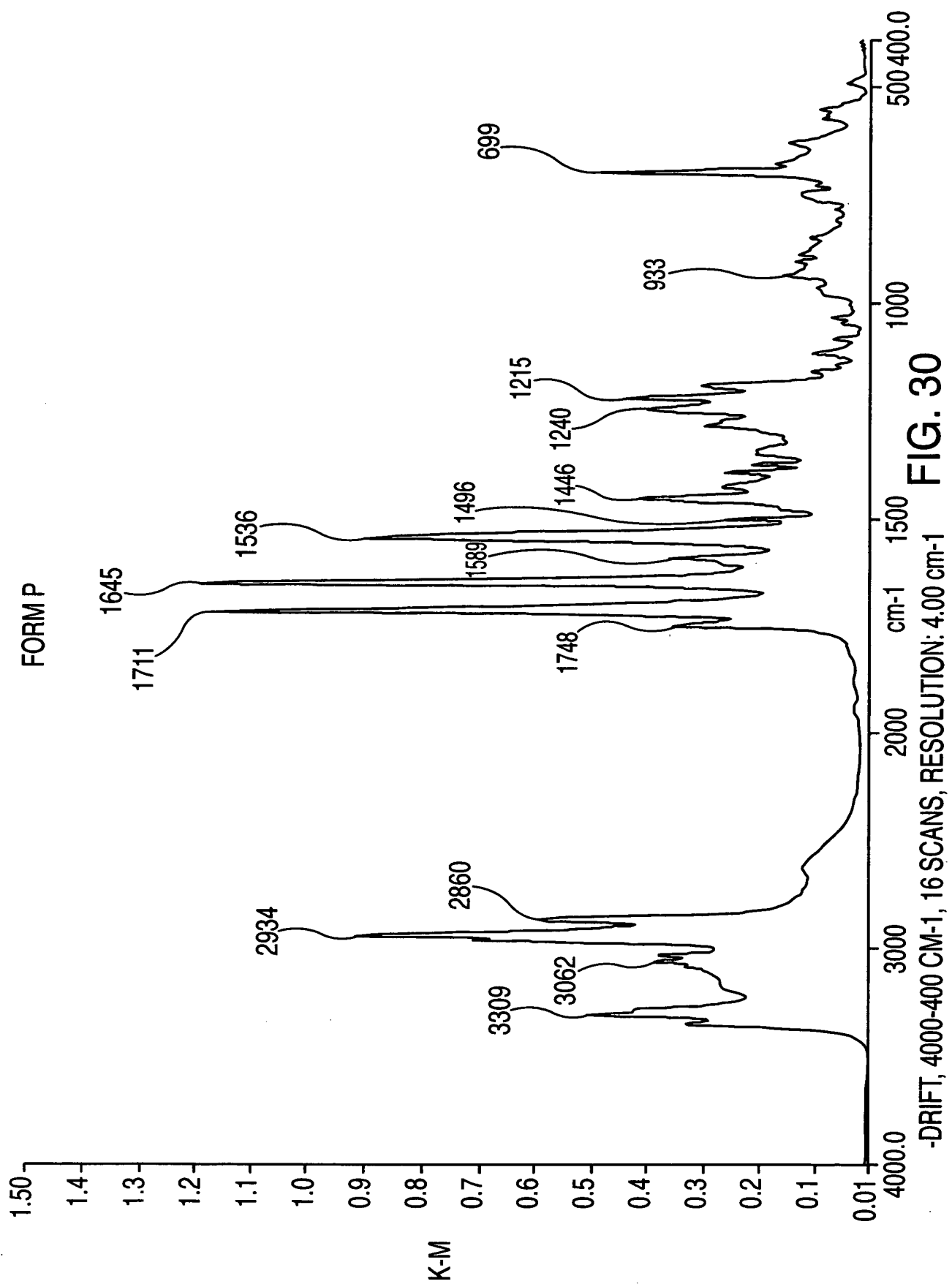
- * TRANSFORMATION MAY PROCEED THROUGH ANOTHER TERM.
 ** THERMALLY STABLE AT LOWER HEATING TEMPERATURES (~50°C).
 *** THERMALLY STABLE FORMS.
 -----> TRANSFORMATION AFTER STORAGE AT ROOM TEMPERATURE.
 m MIXTURE WITH STARTING FORM.
 ***** WHEN STARTING MATERIAL CONTAINS SEEDS.
 sol RESULTS MIGHT VARY DEPENDING ON THE SOLVATE OF FORM EPSILON USED.

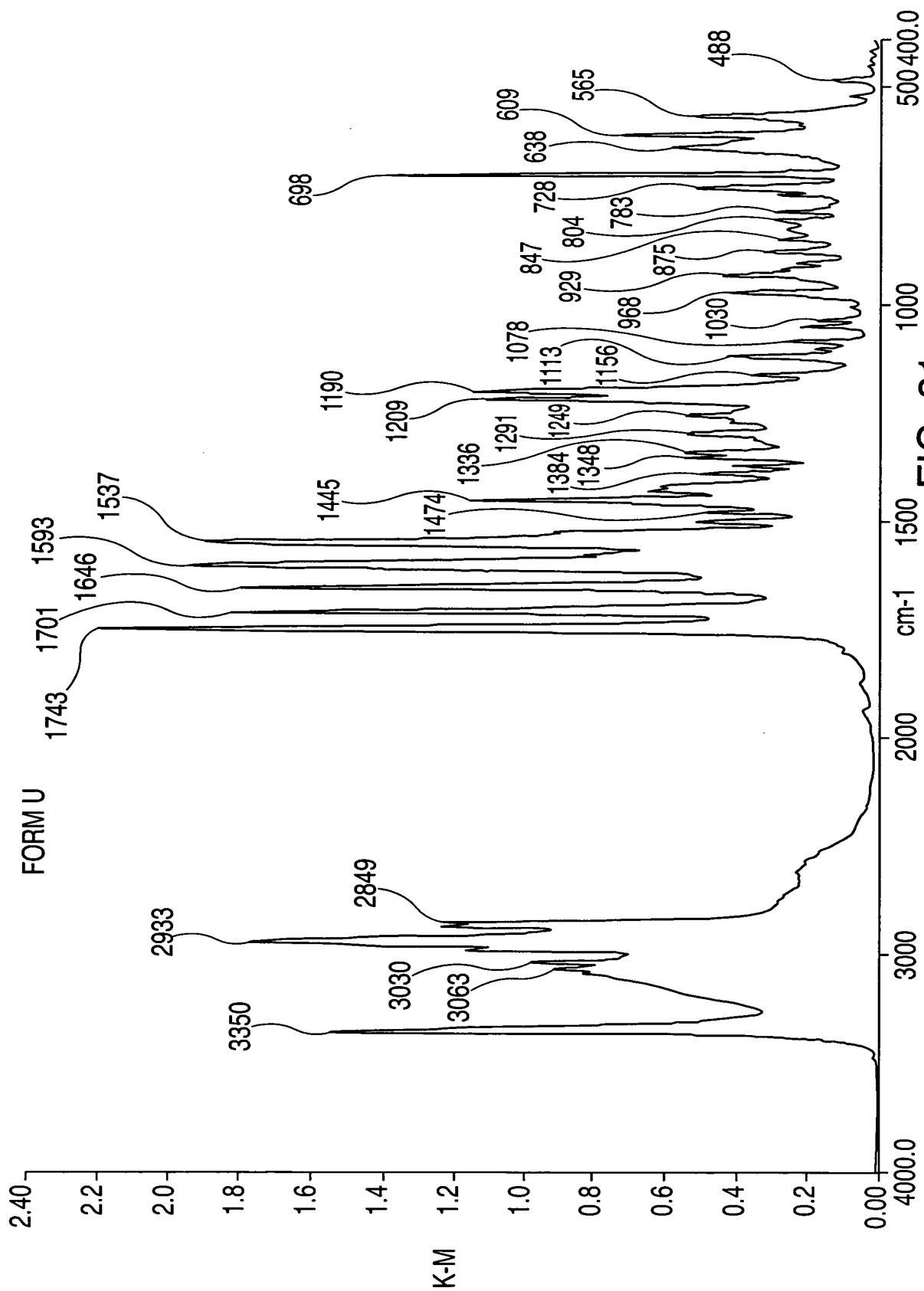
THERMAL STABILITY CHART

FIG. 28

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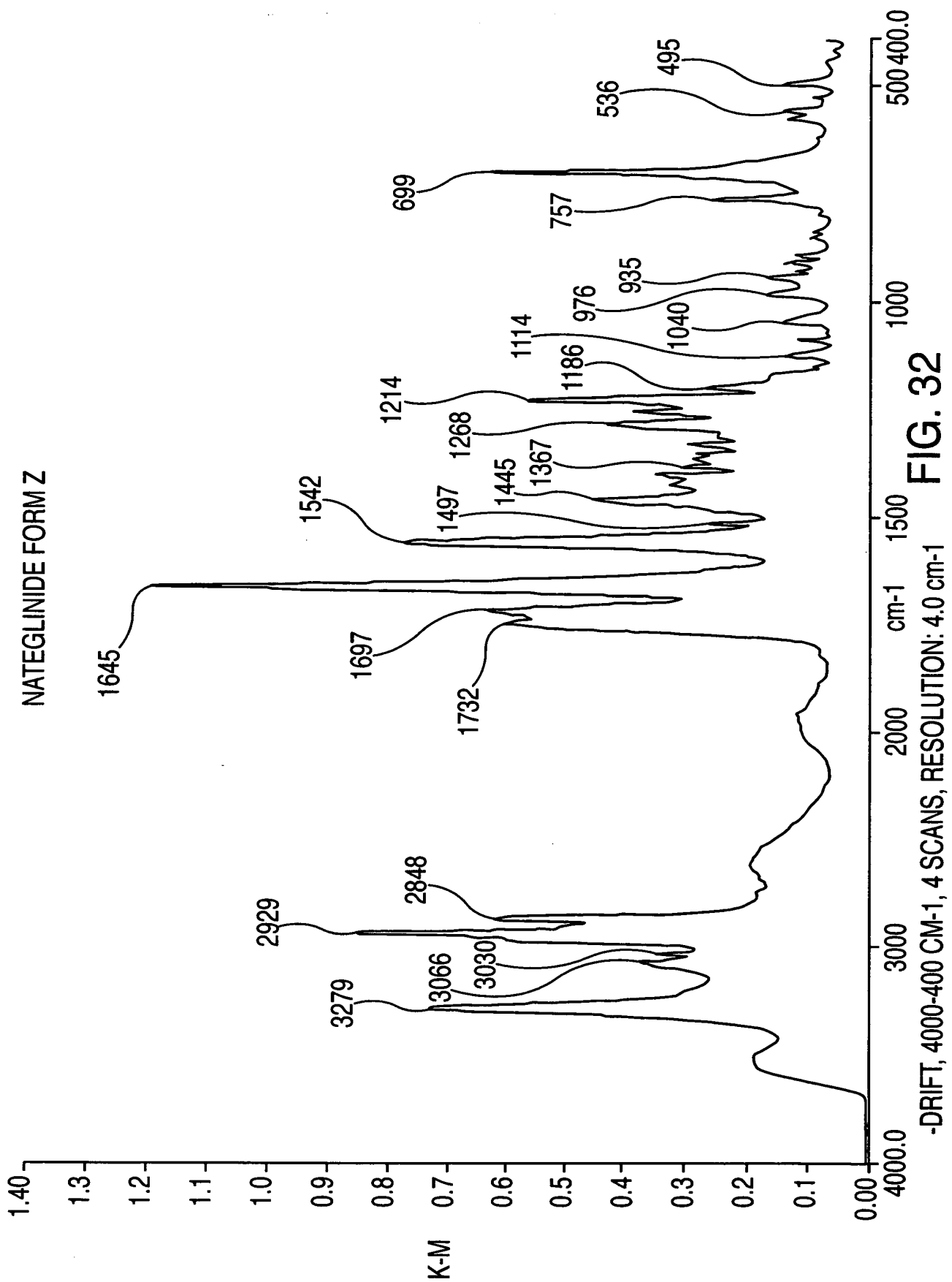


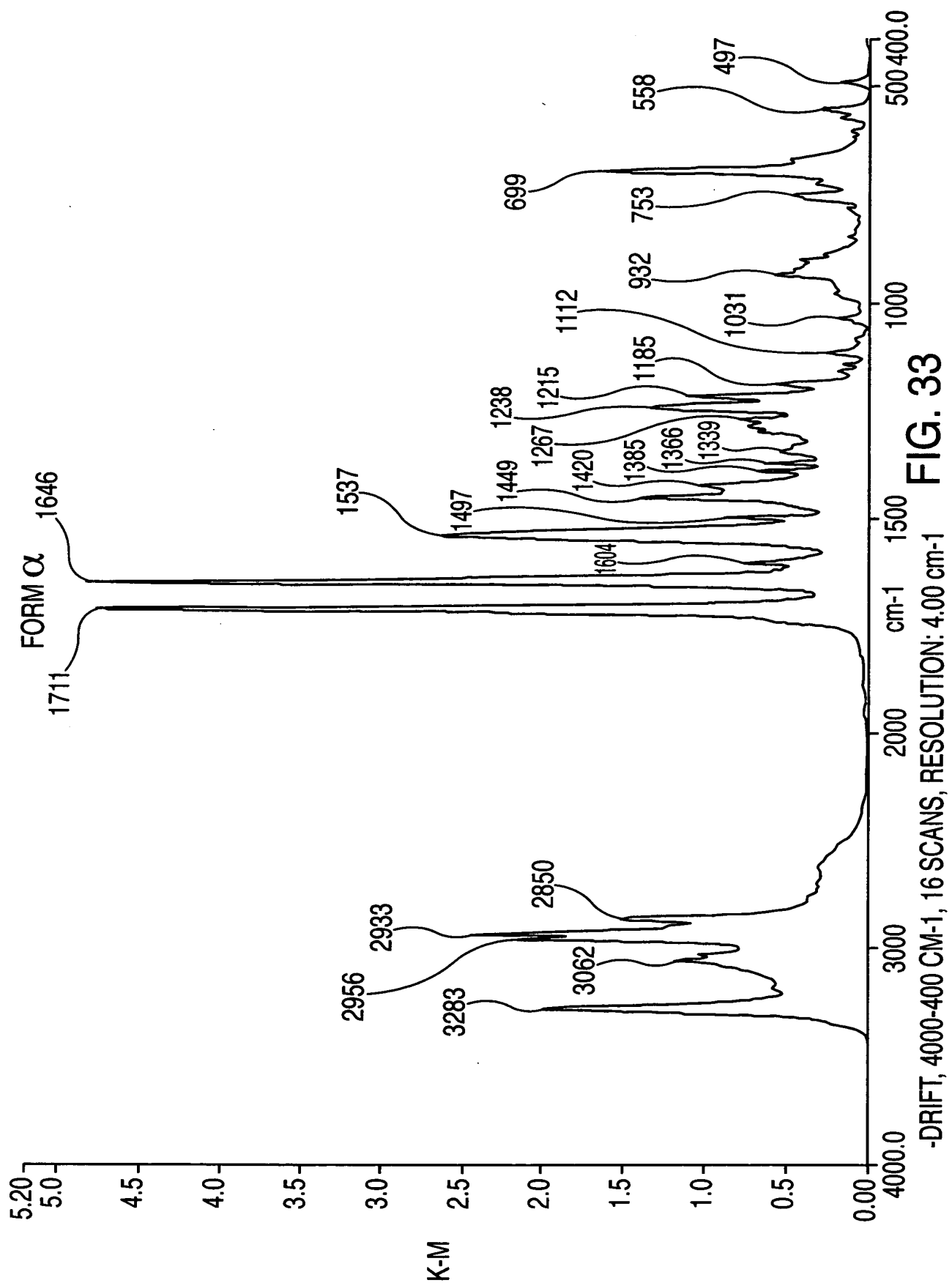


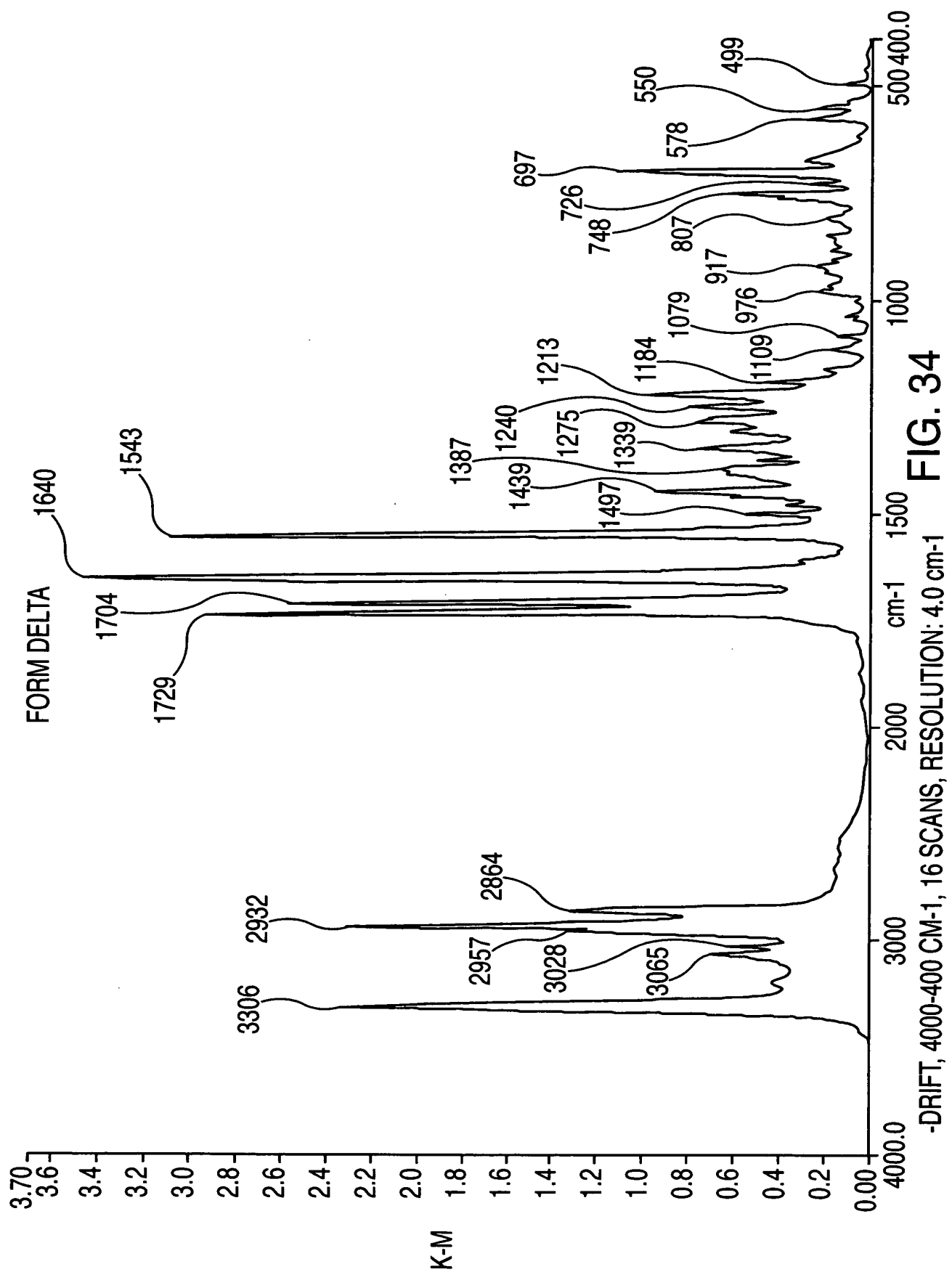


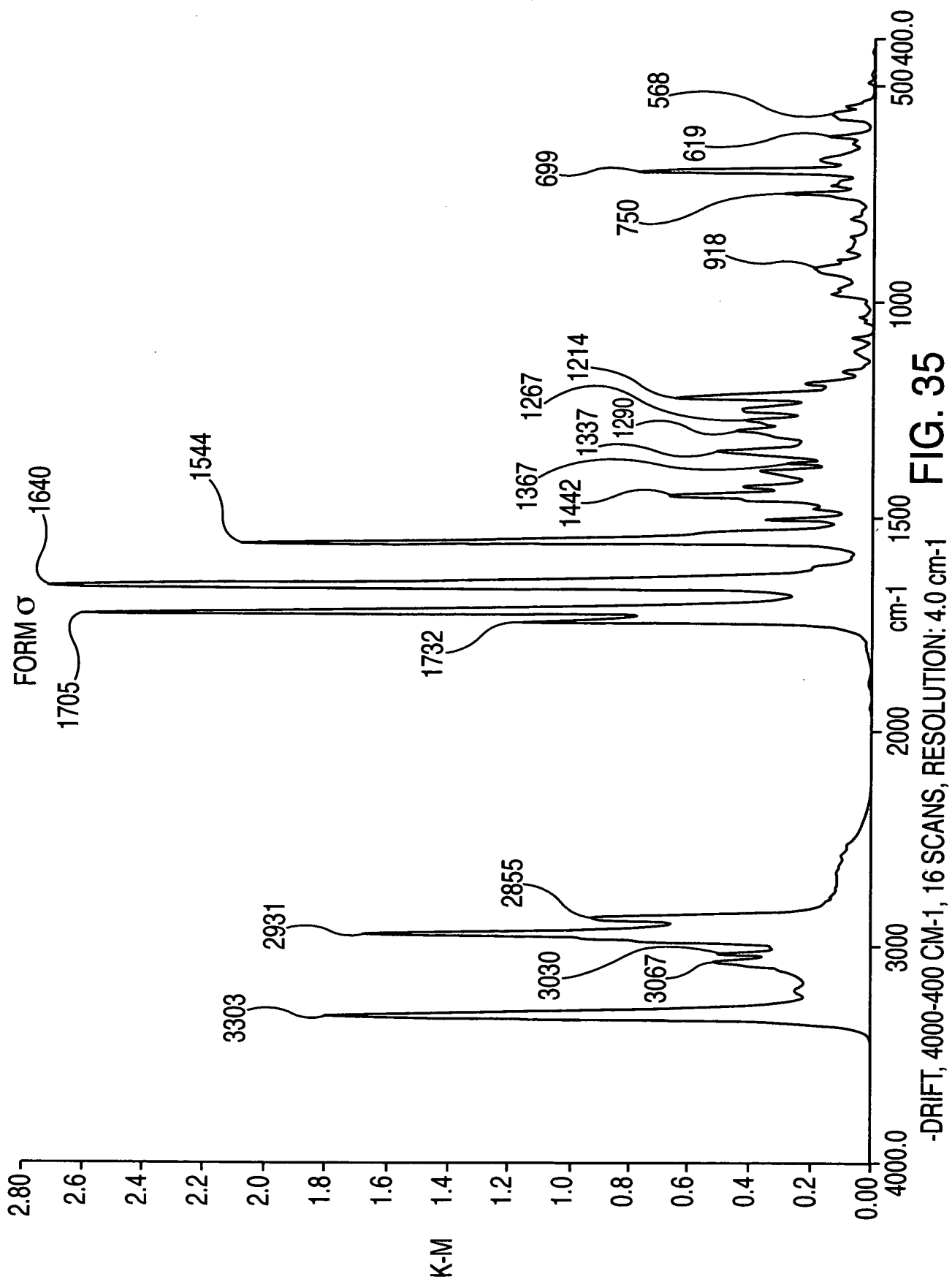
-DRIFT, 4000-400 CM-1, 16 SCANS, RESOLUTION: 4.0 CM-1

FIG. 31









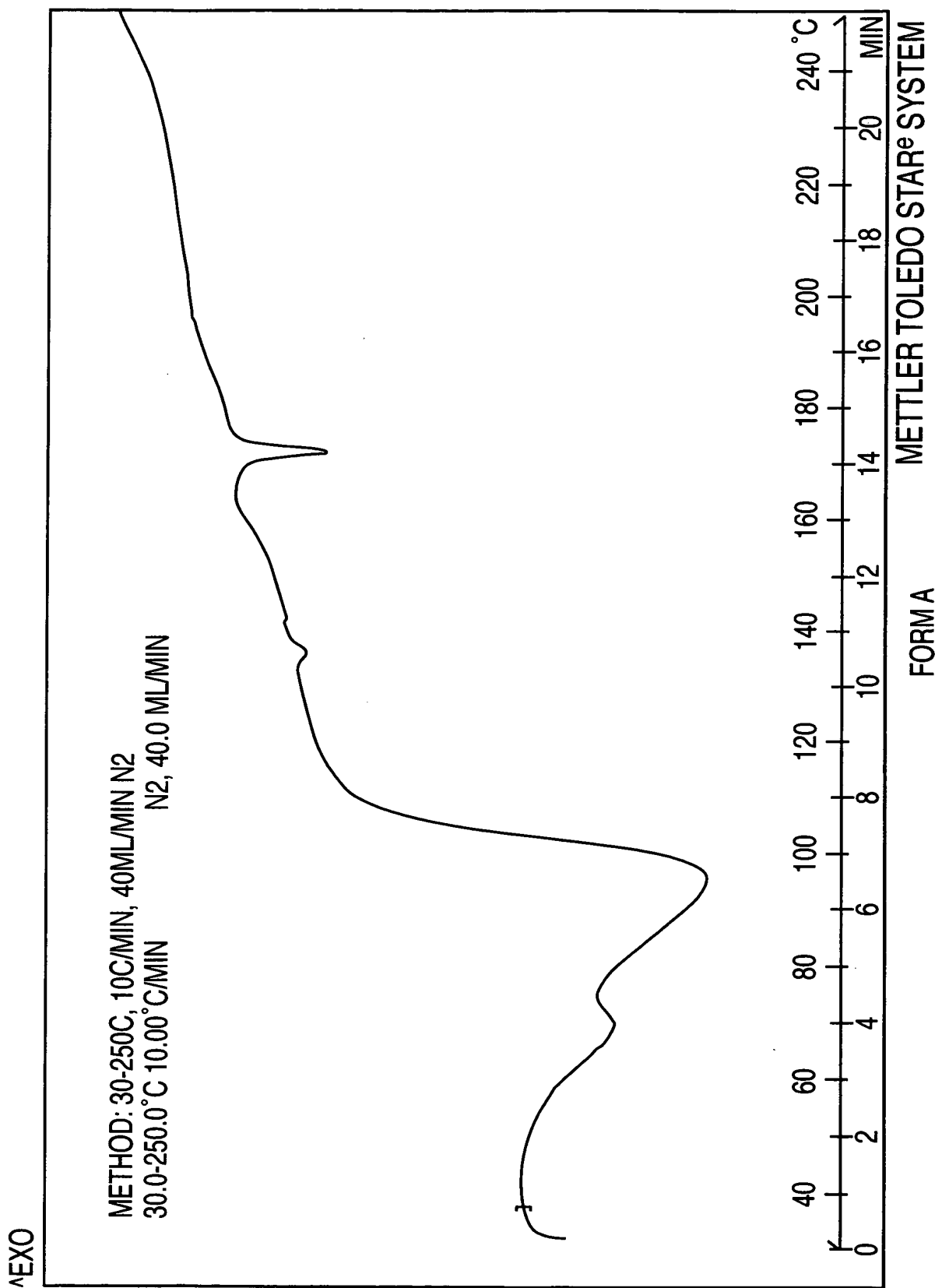
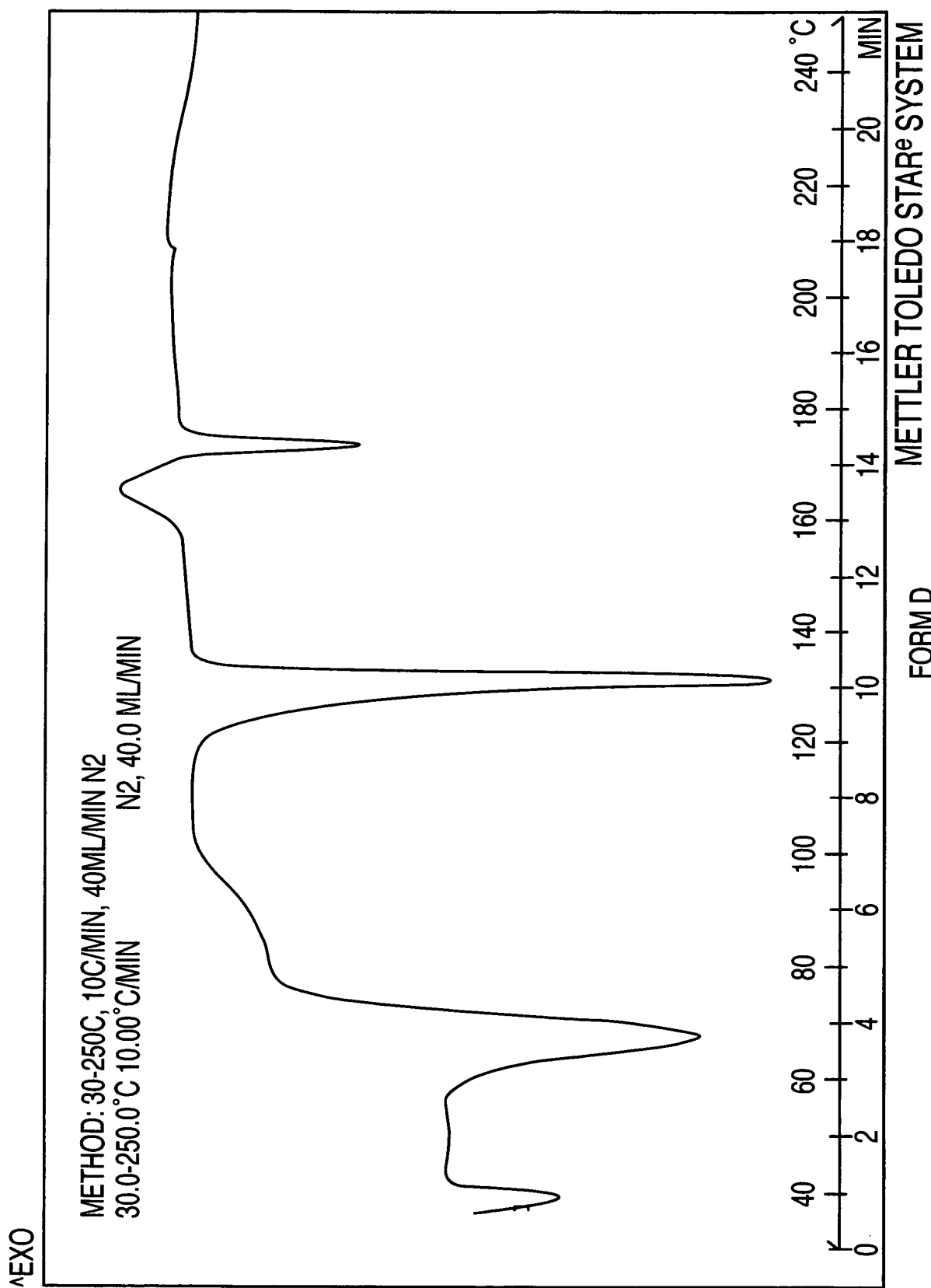


FIG. 36



FORM D
FIG. 37

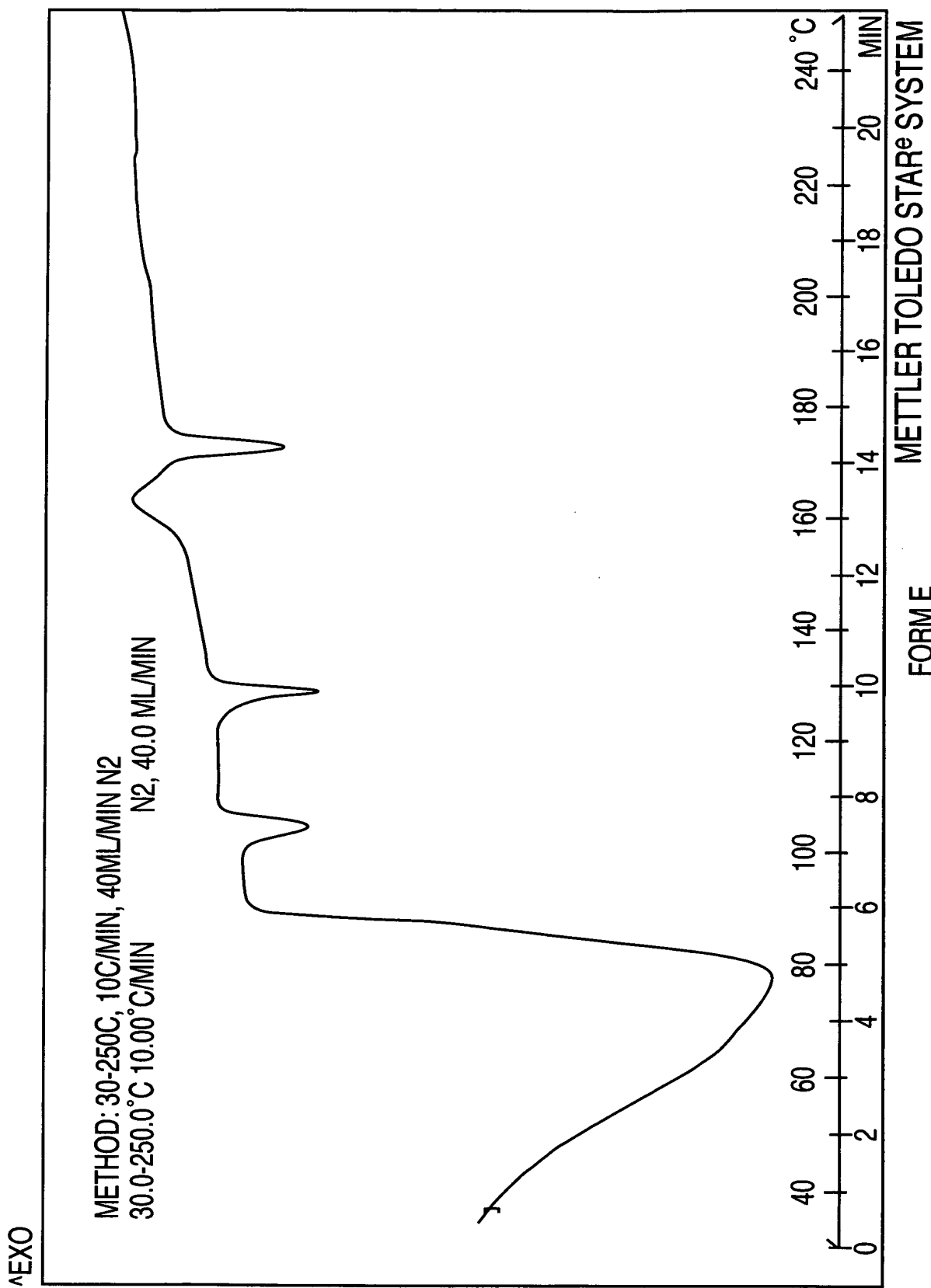


FIG. 38

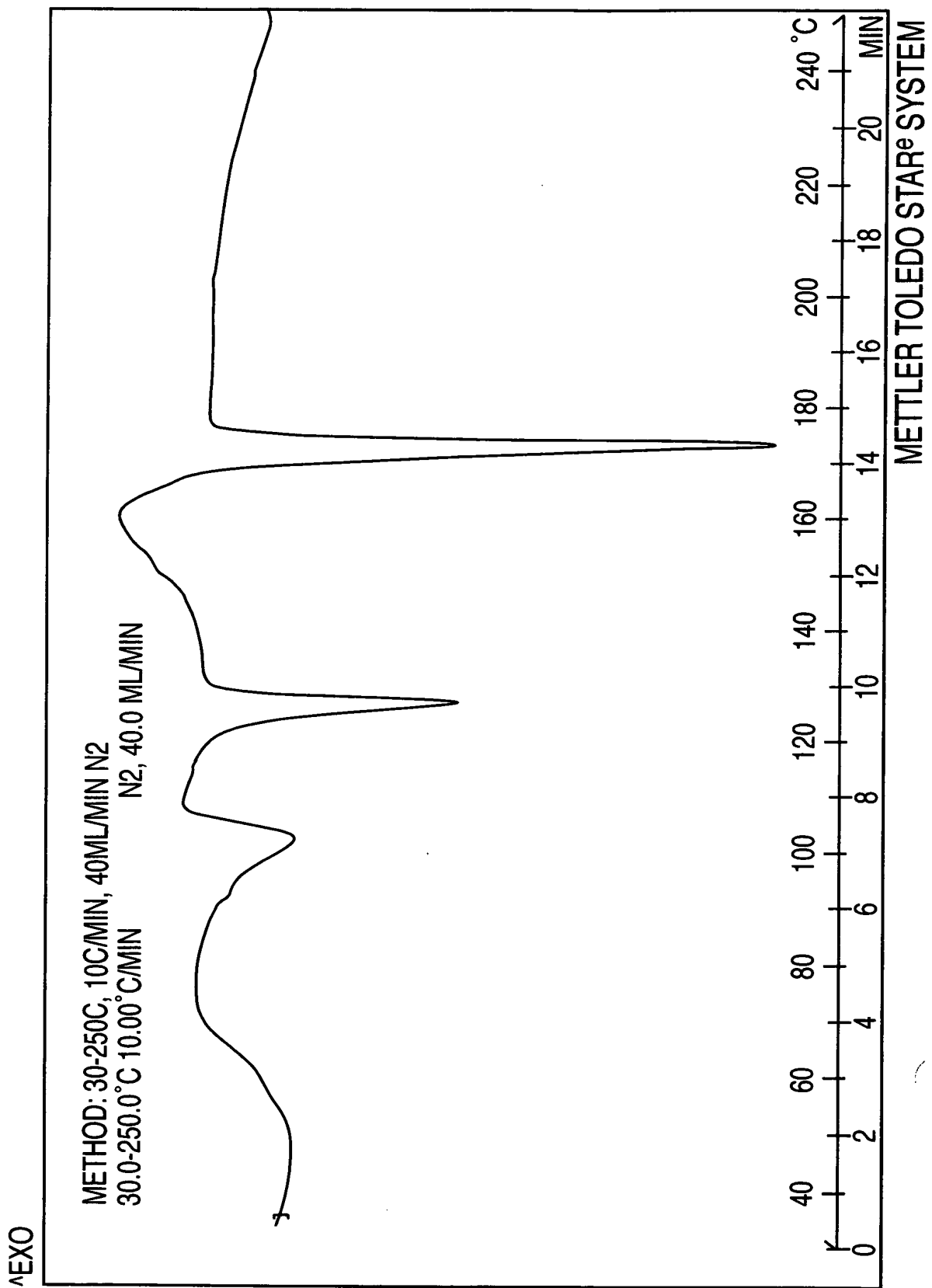


FIG. 39

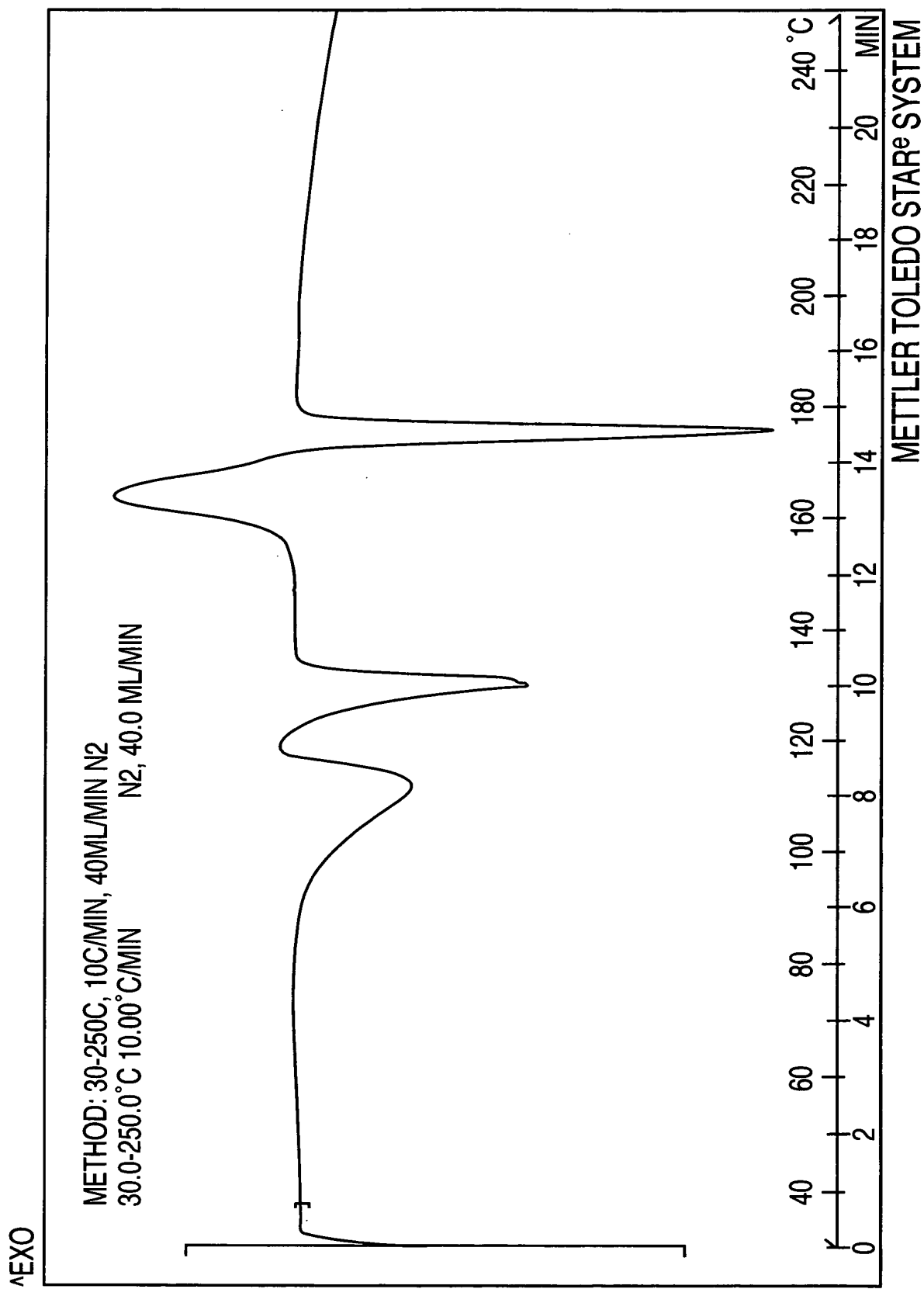
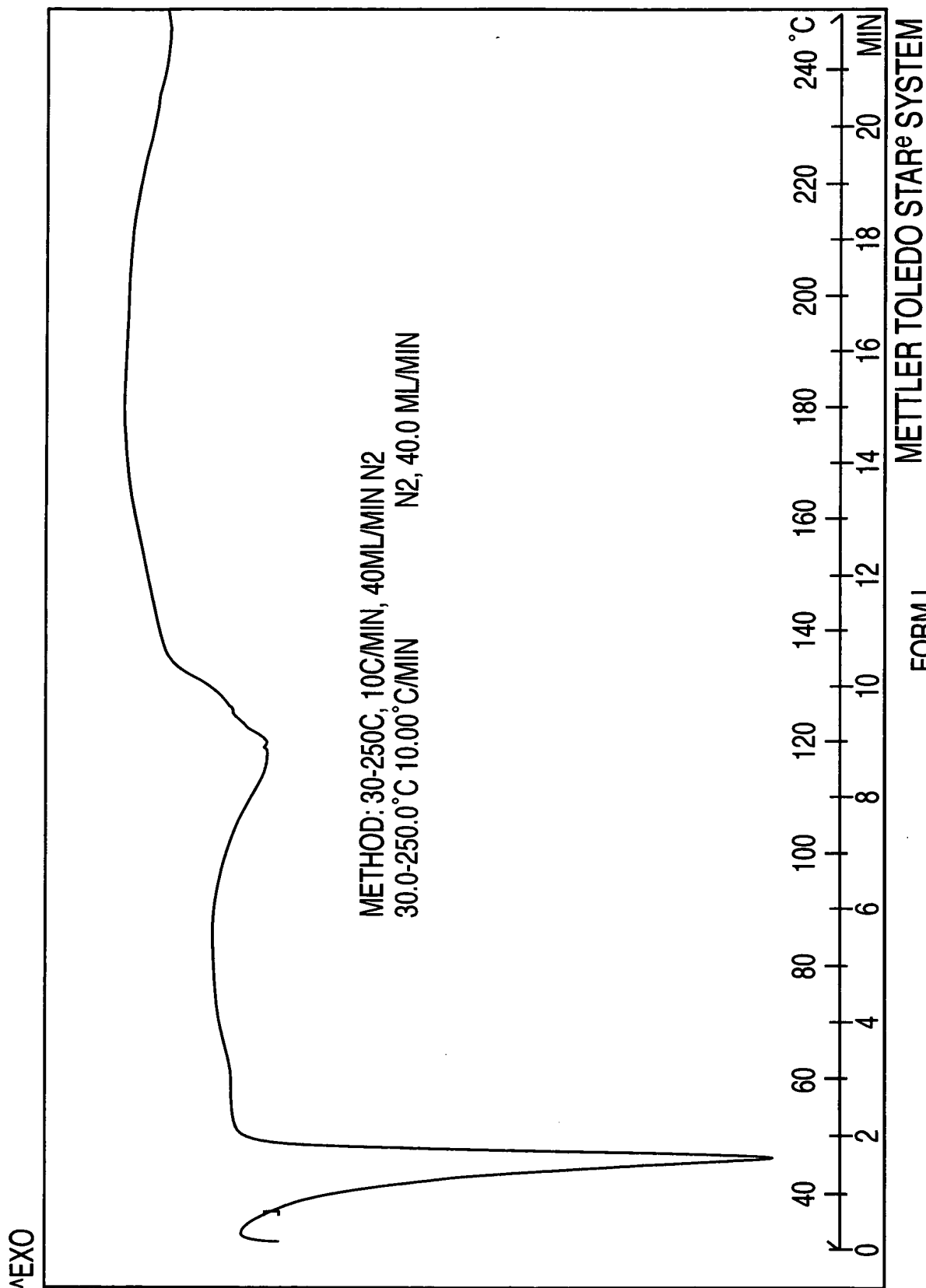


FIG. 40

FORM I
FIG. 41

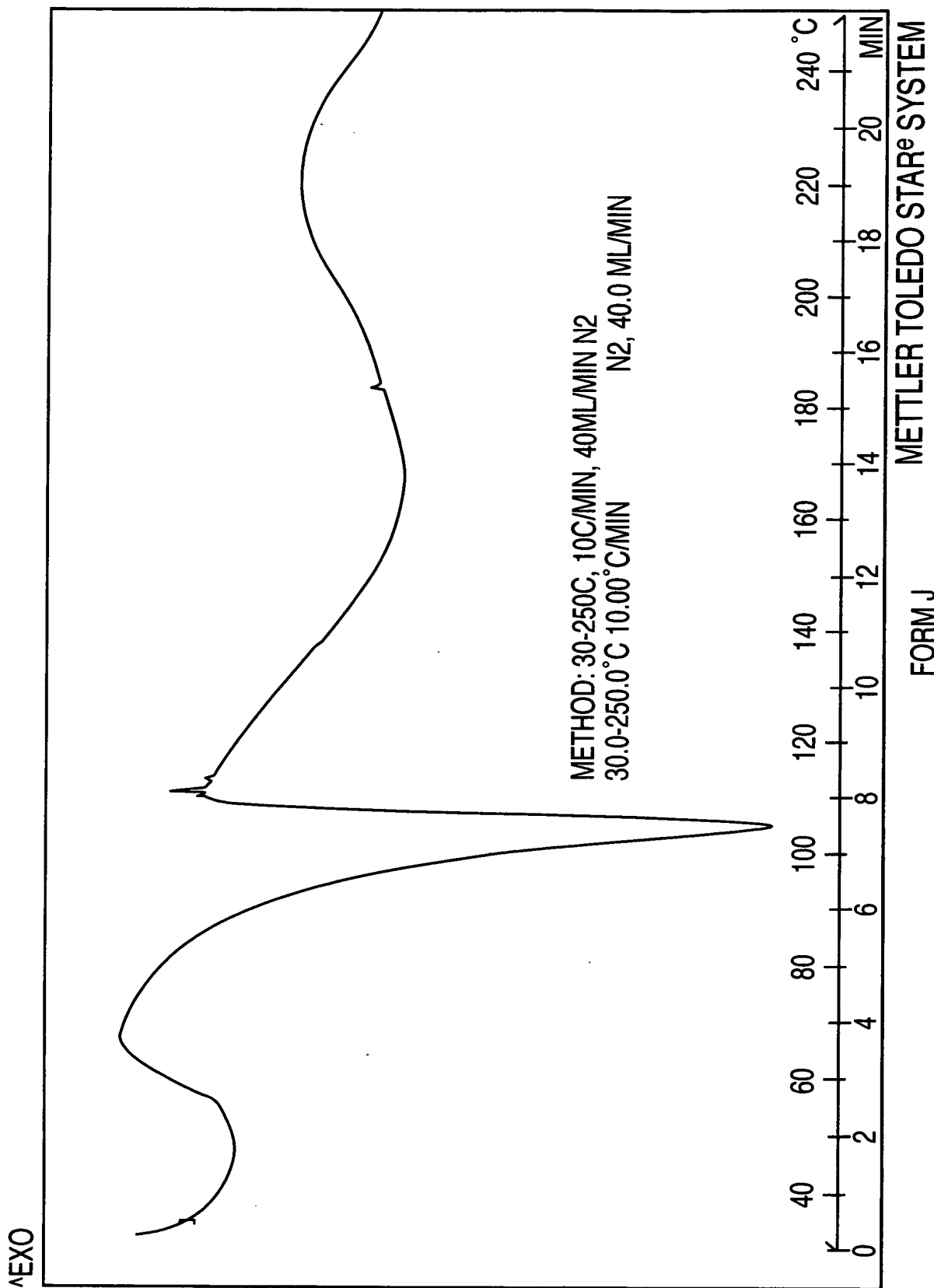
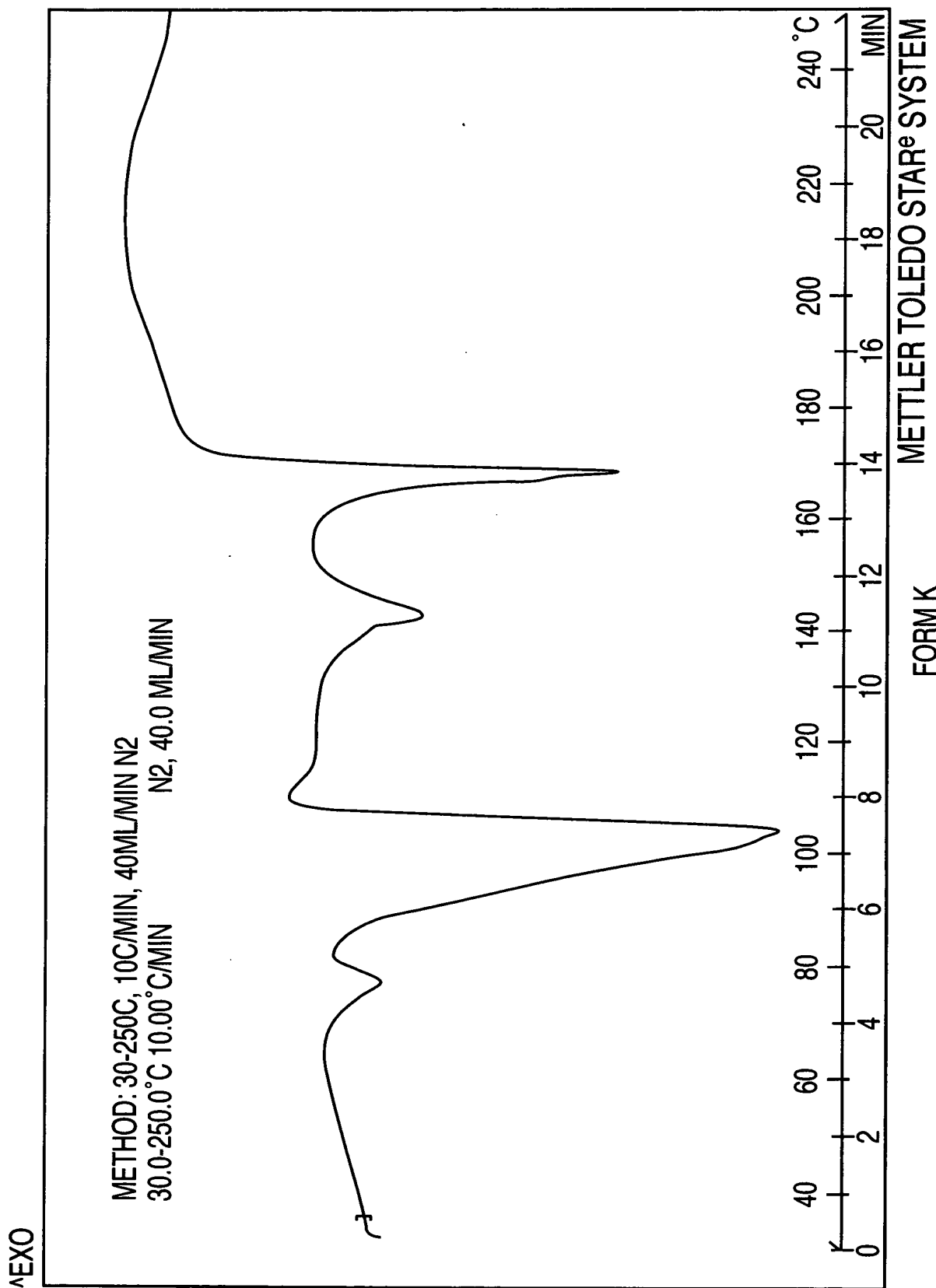
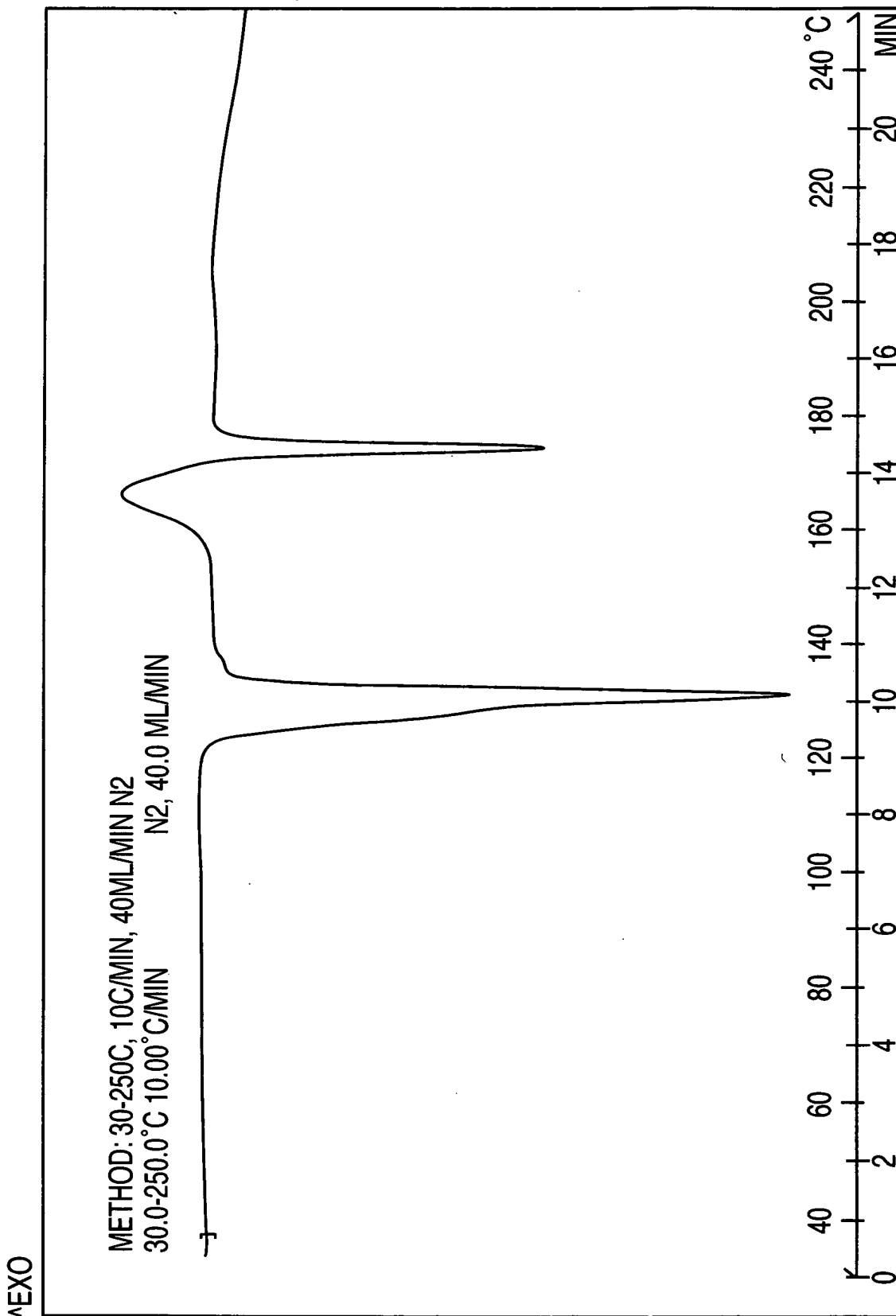


FIG. 42

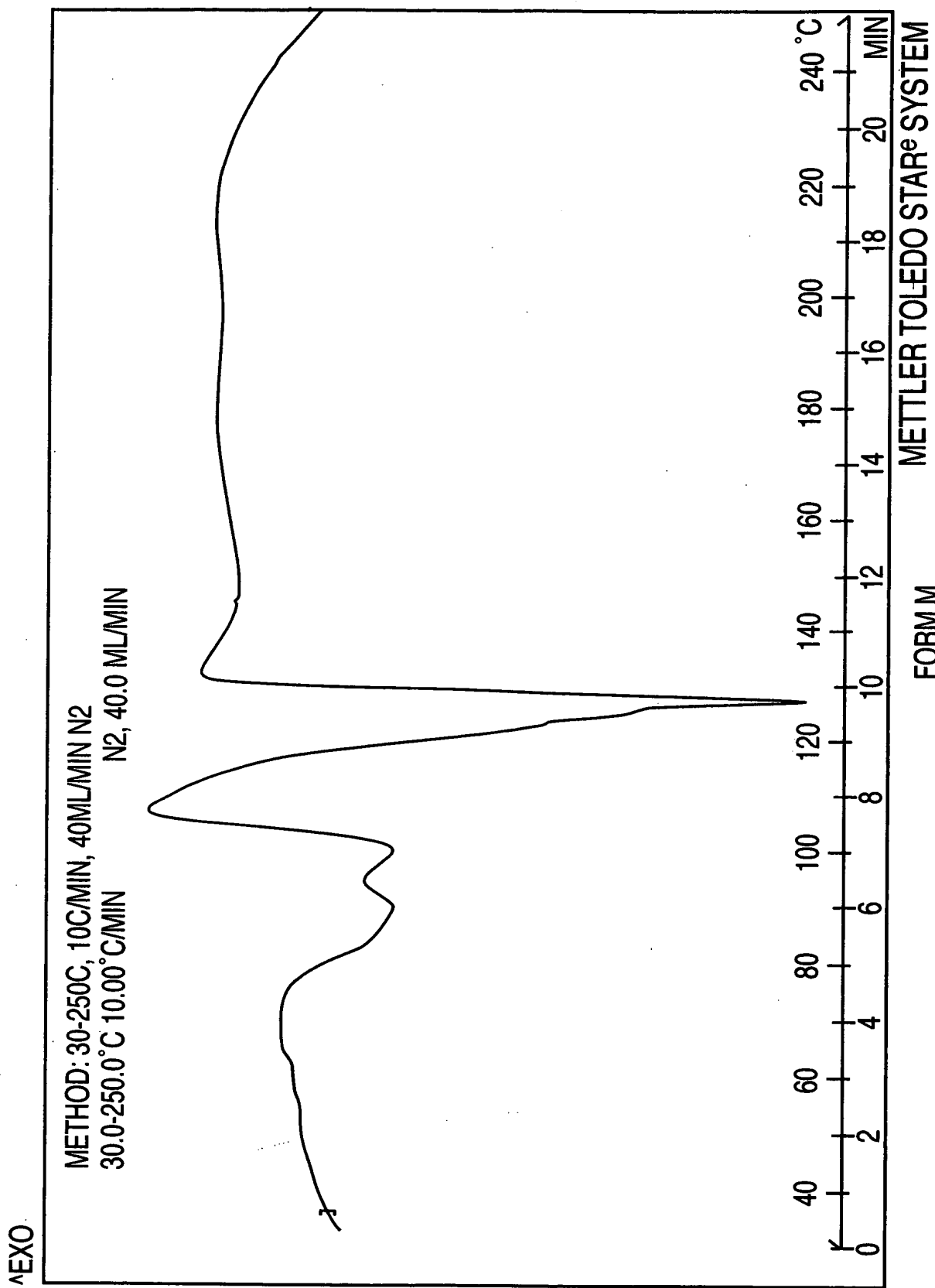
FORM K
FIG. 43



FORM L

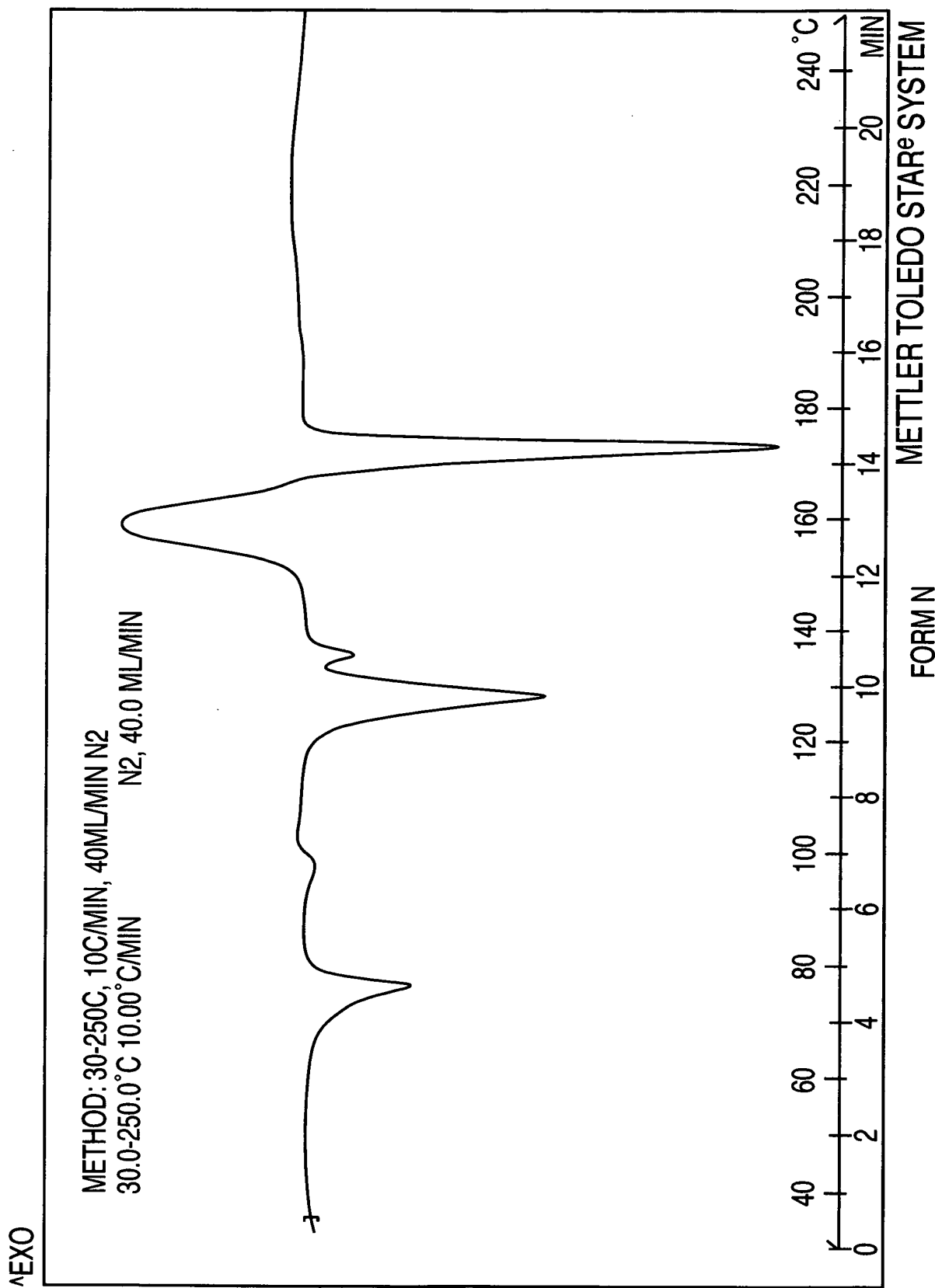
FIG. 44

METTLER TOLEDO STAR^e SYSTEM

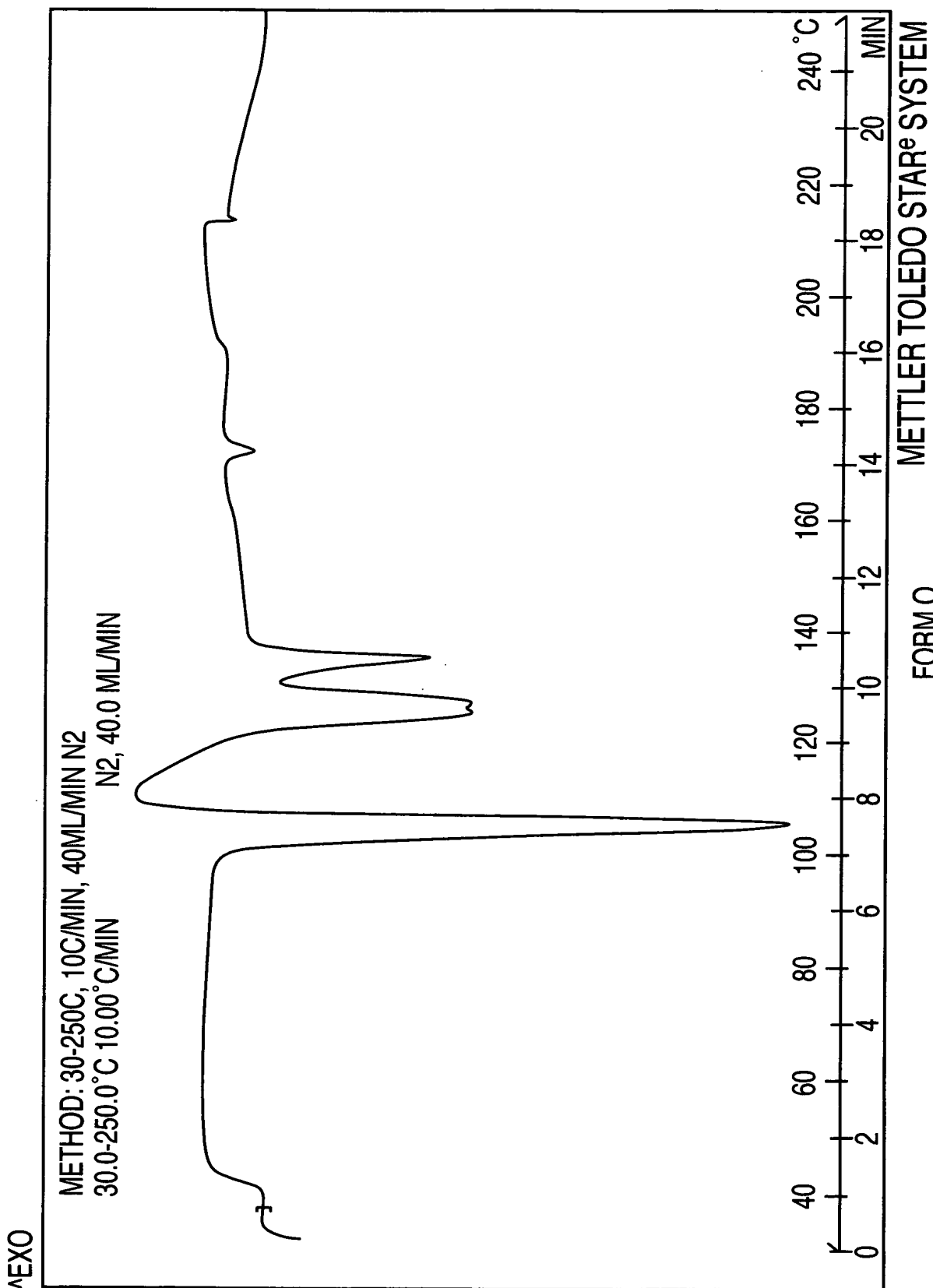


FORM M

FIG. 45

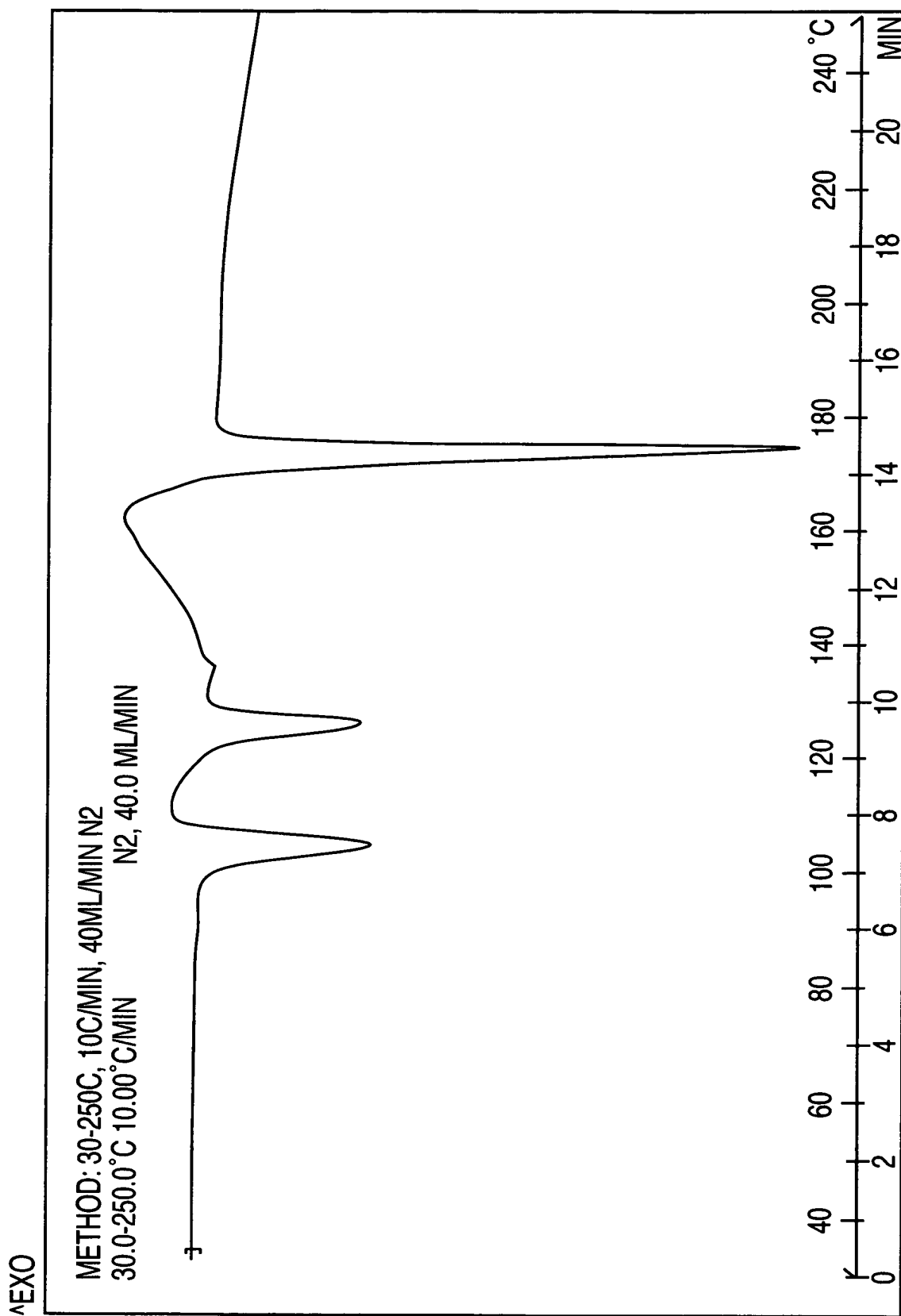


FORM N
FIG. 46



FORM O

FIG. 47

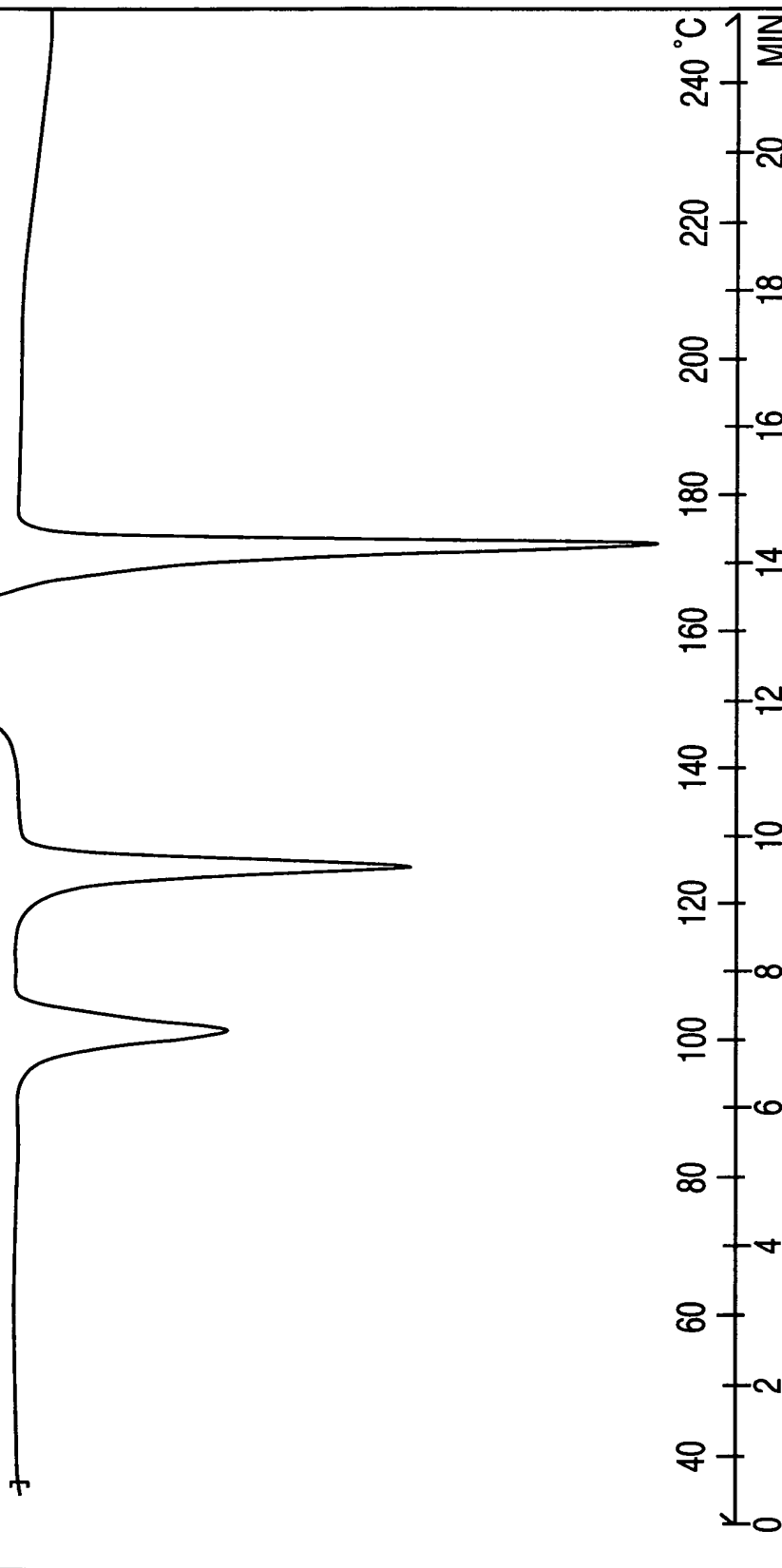
METTLER TOLEDO STAR^e SYSTEM

FORM P

FIG. 48

^EXO

METHOD: 30-250C, 10C/MIN, 40ML/MIN N2
30.0-250.0°C 10.00°C/MIN
N2, 40.0 ML/MIN



METTLER TOLEDO STAR^e SYSTEM

FORM Q

FIG. 49

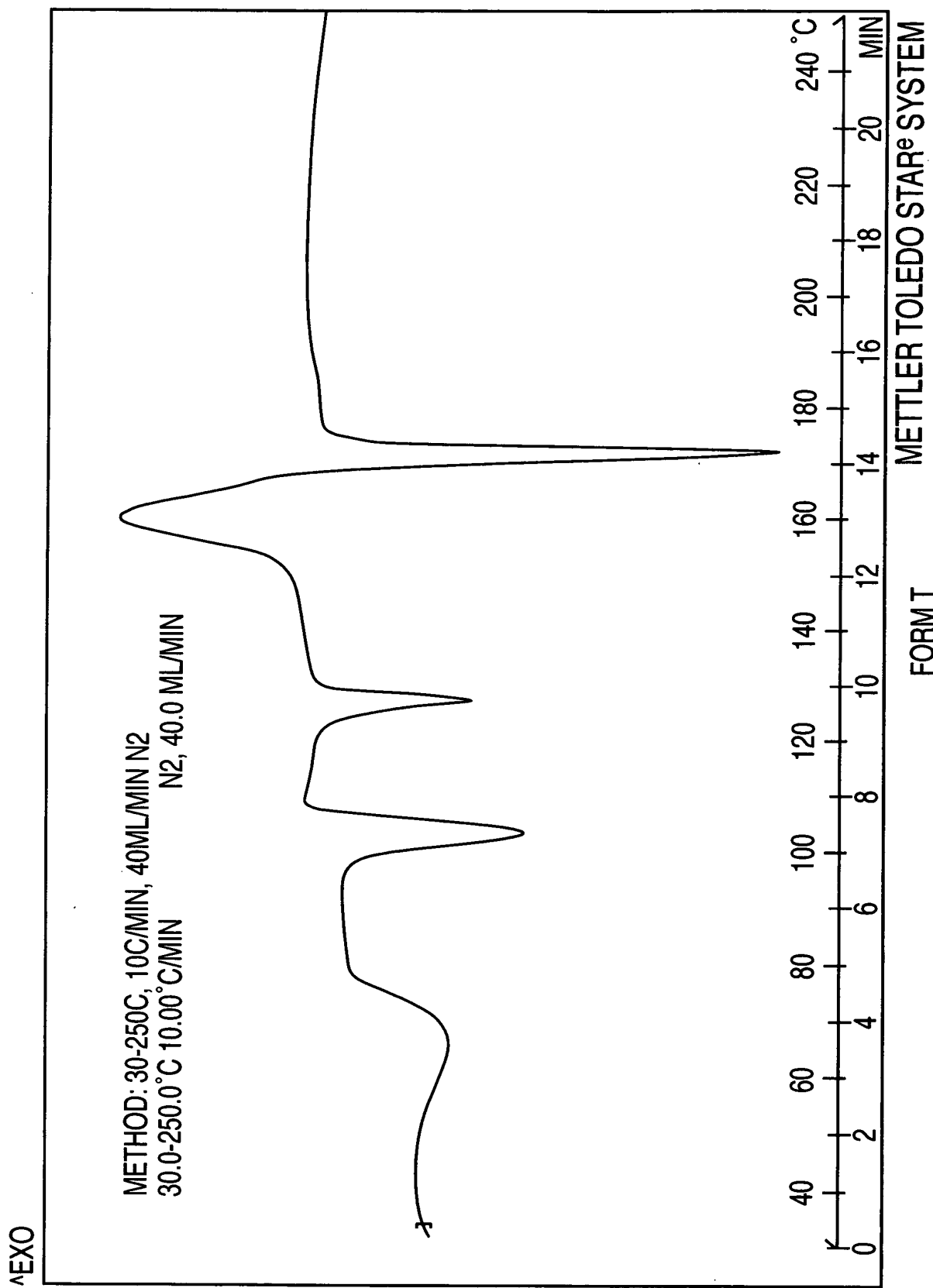
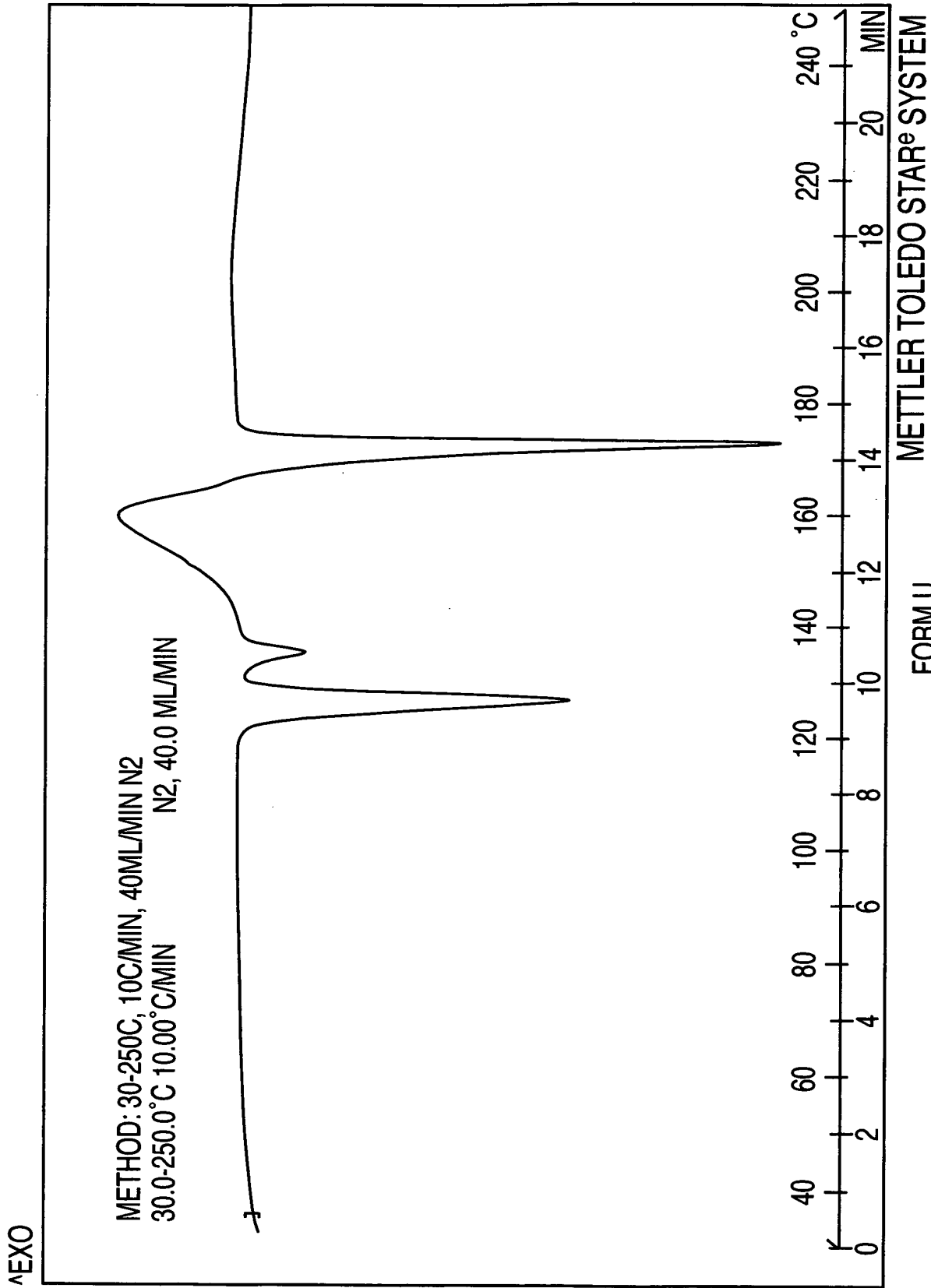


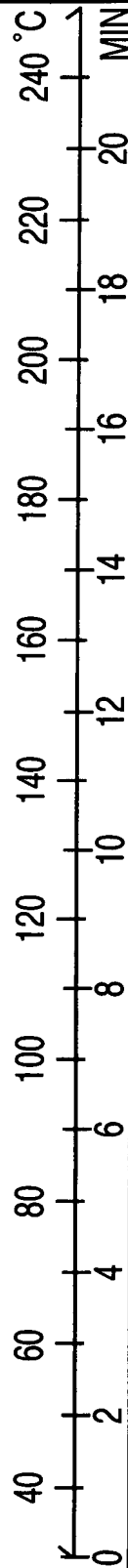
FIG. 50



FORM U

FIG. 51

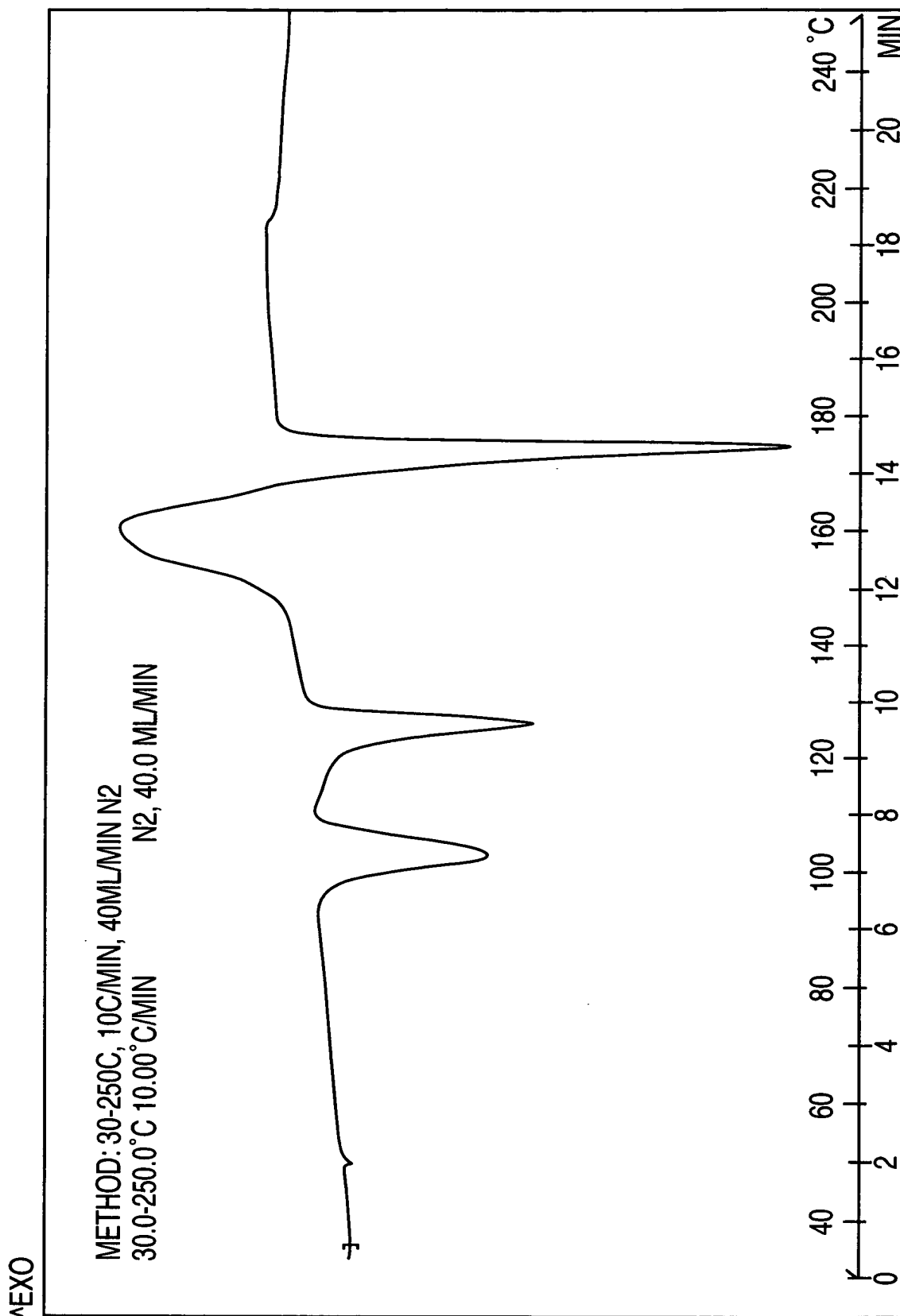
7



METTLER TOLEDO STAR^e SYSTEM

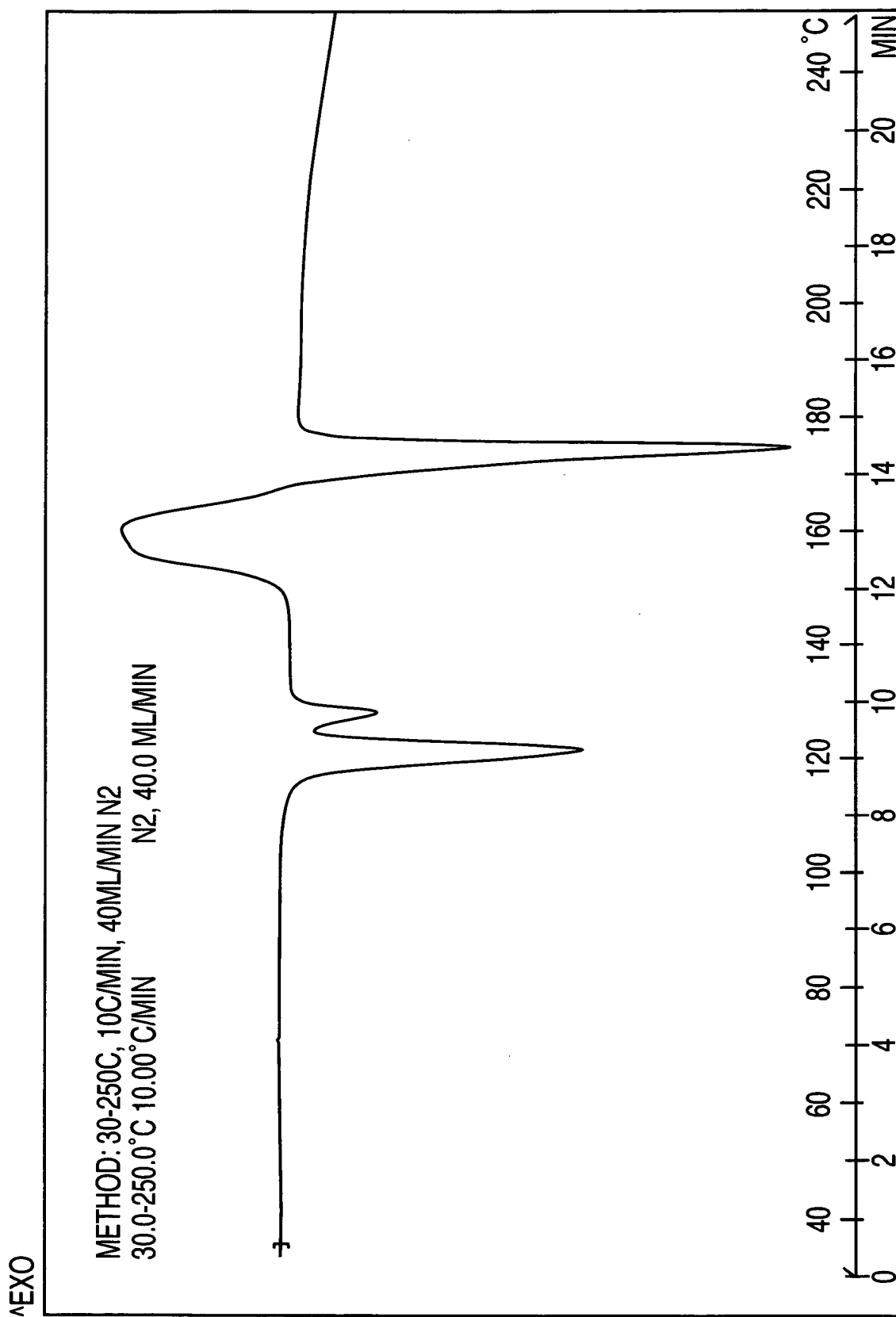
FORM V

FIG. 52



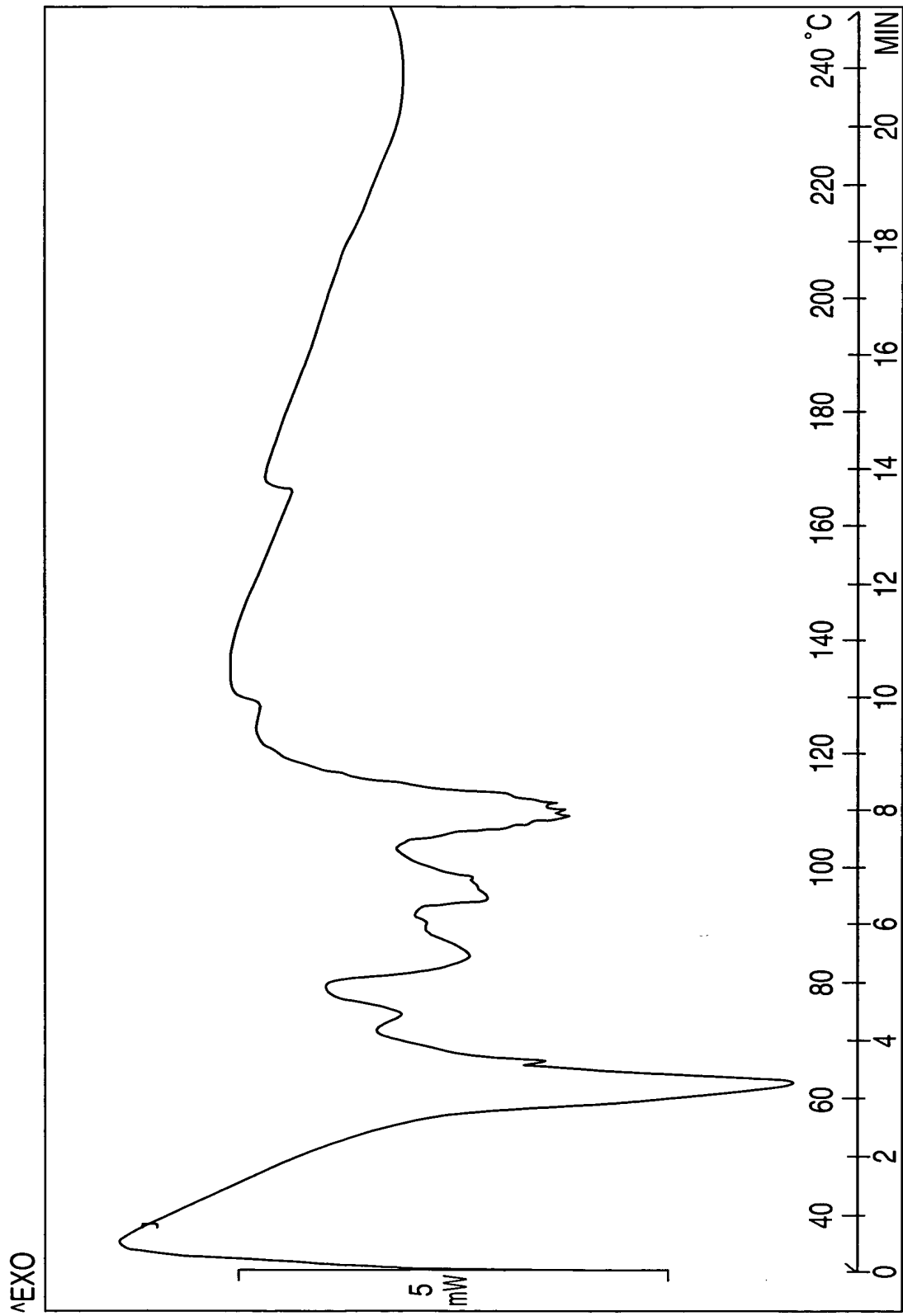
FORM Y (CHLOROFORM SOLVATE) METTLER TOLEDO STAR^e SYSTEM

FIG. 53

METTLER TOLEDO STAR^e SYSTEM

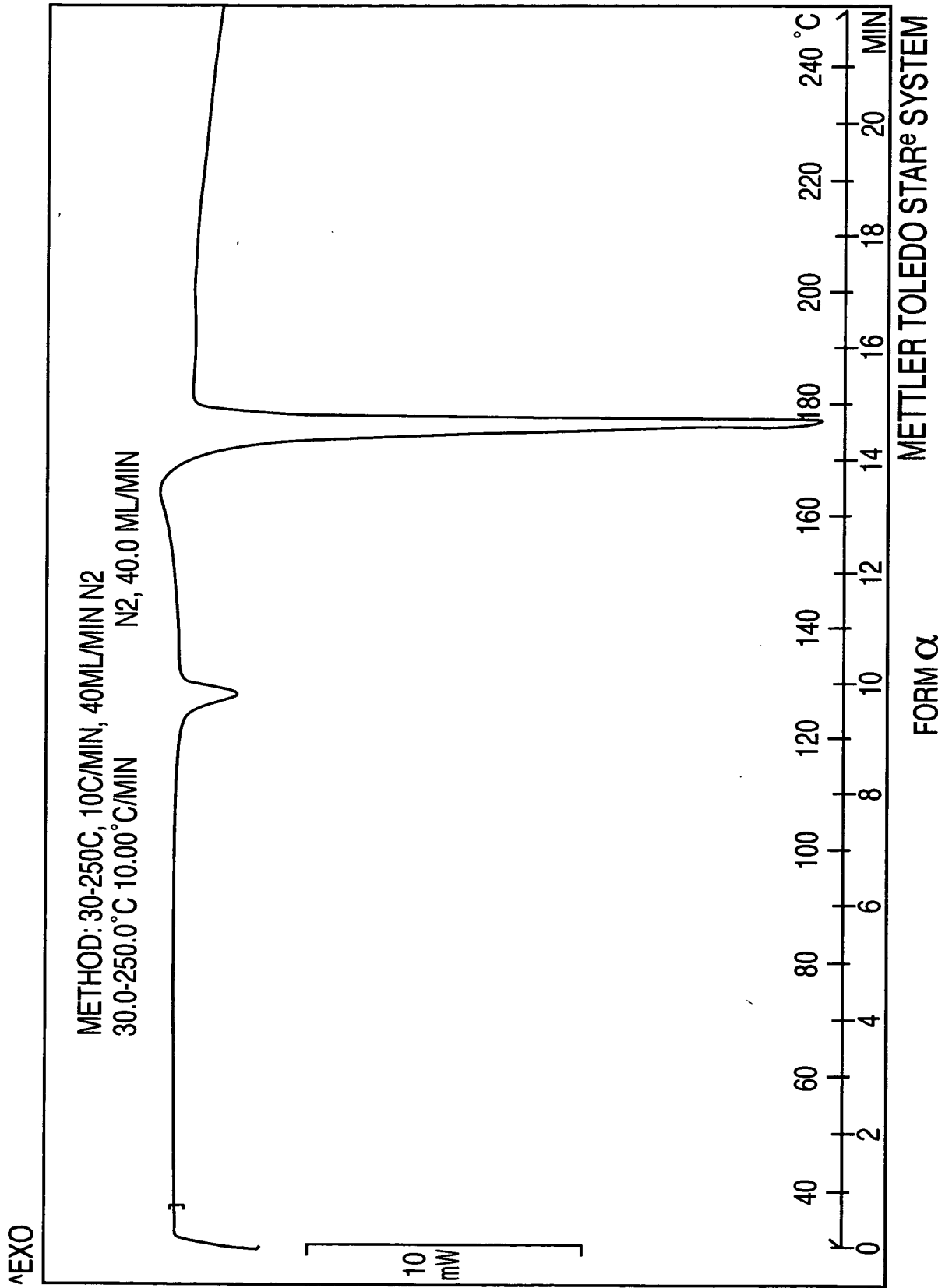
FORM Y (DICHLOROMETHENE SOLVATE)

FIG. 54



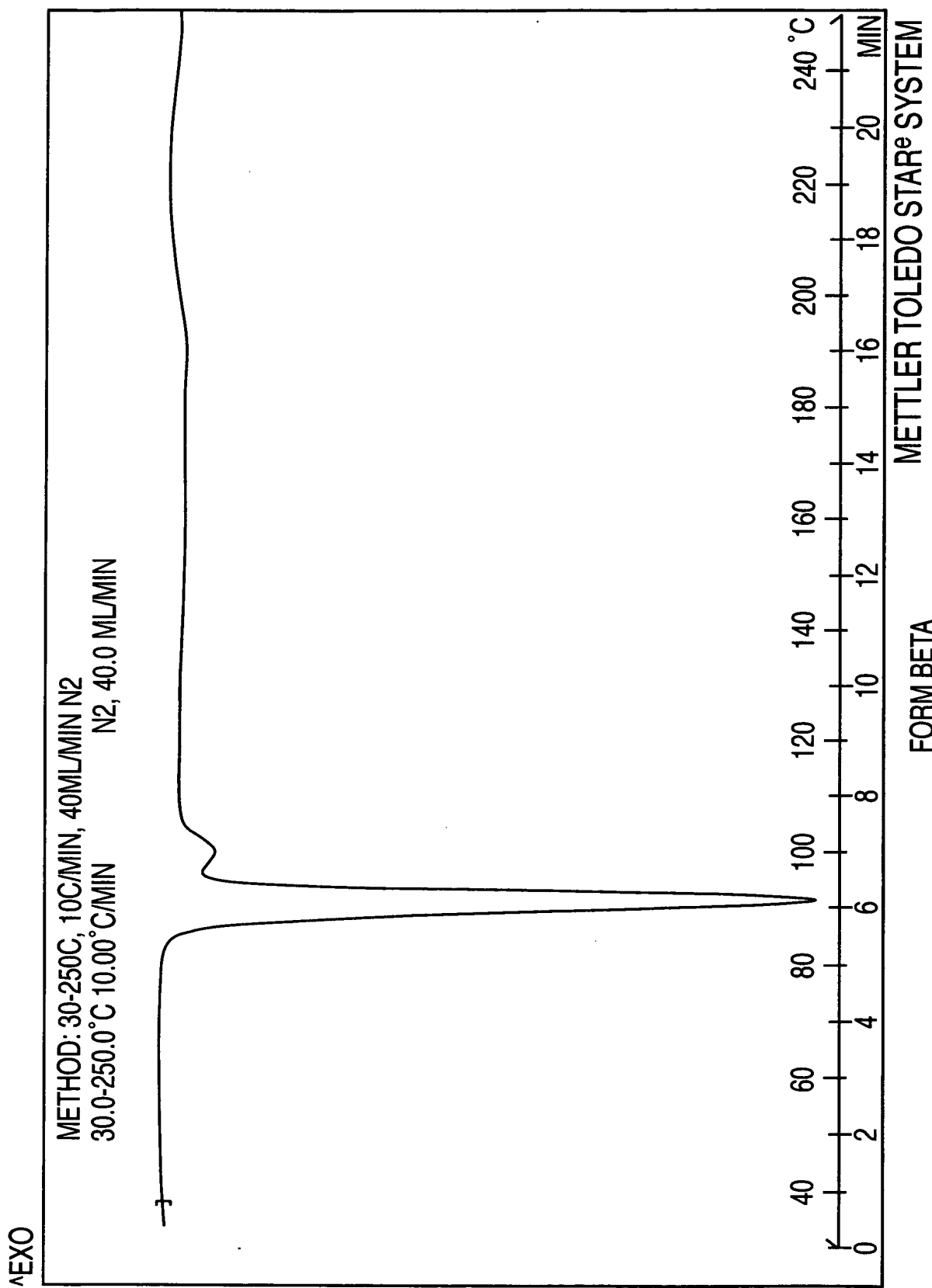
NATEGLINIDE FORM Z METTLER TOLEDO STAR® SYSTEM

FIG. 55



FORM α

FIG. 56



FORM BETA

FIG. 57

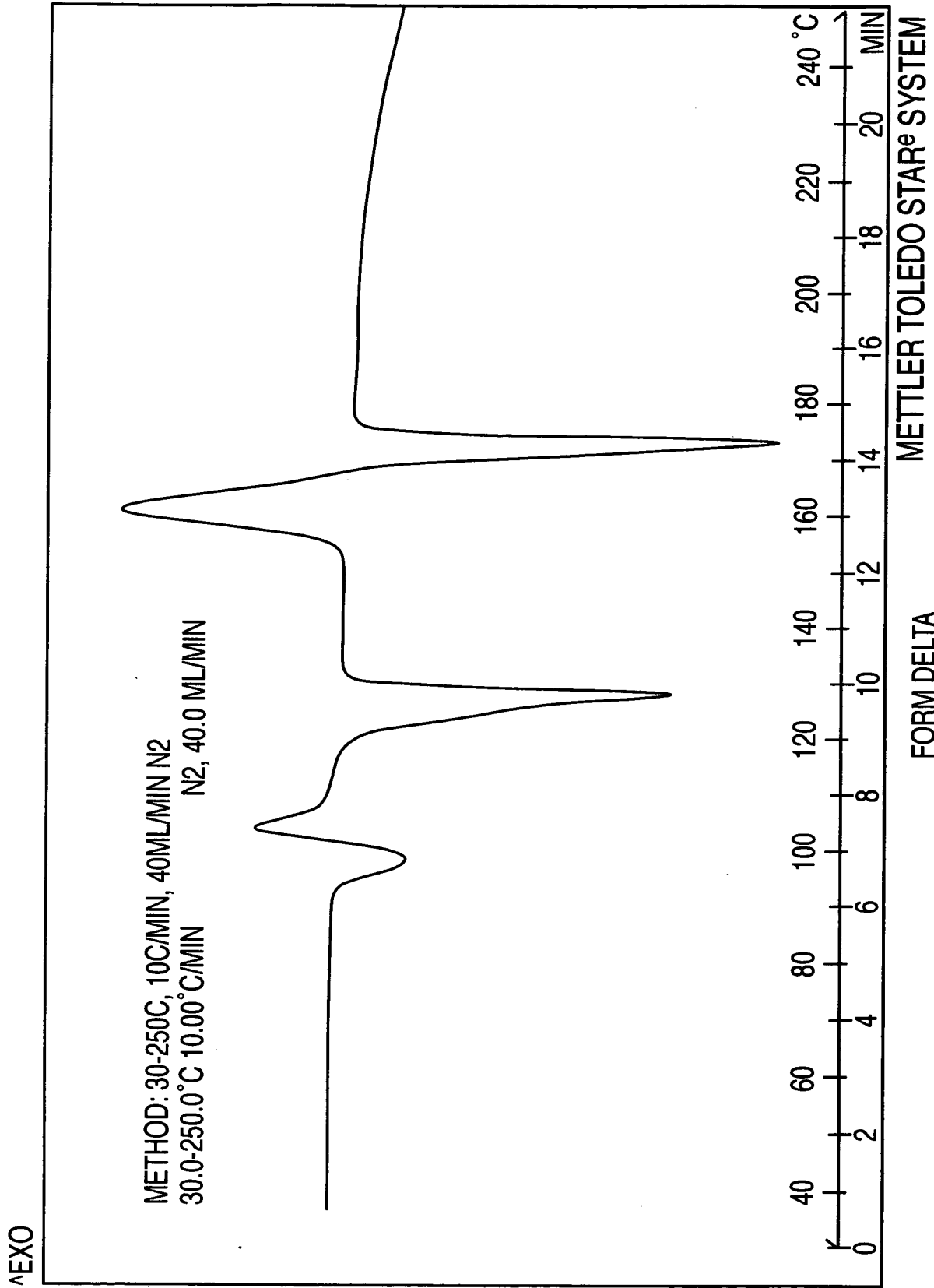


FIG. 58

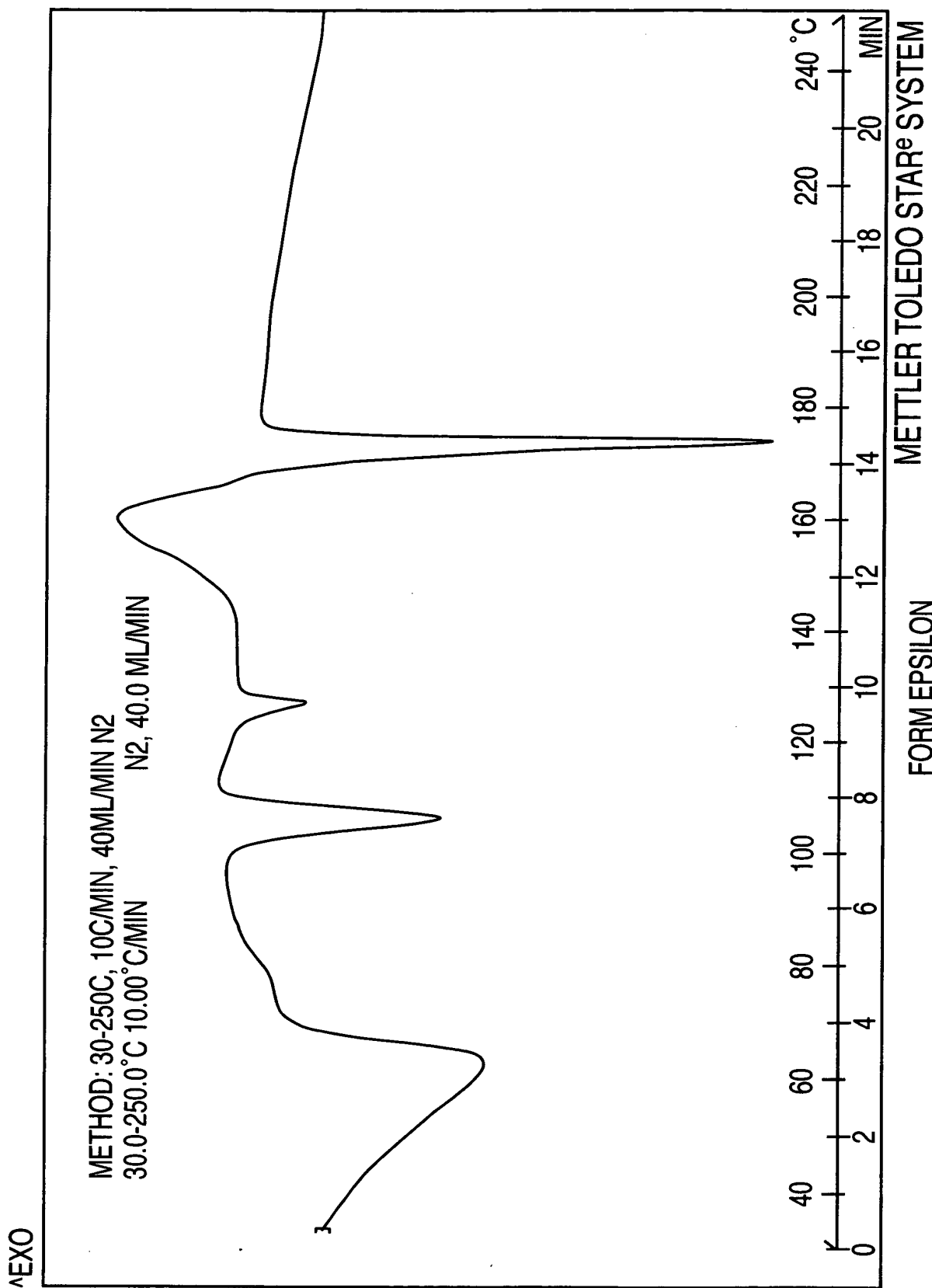
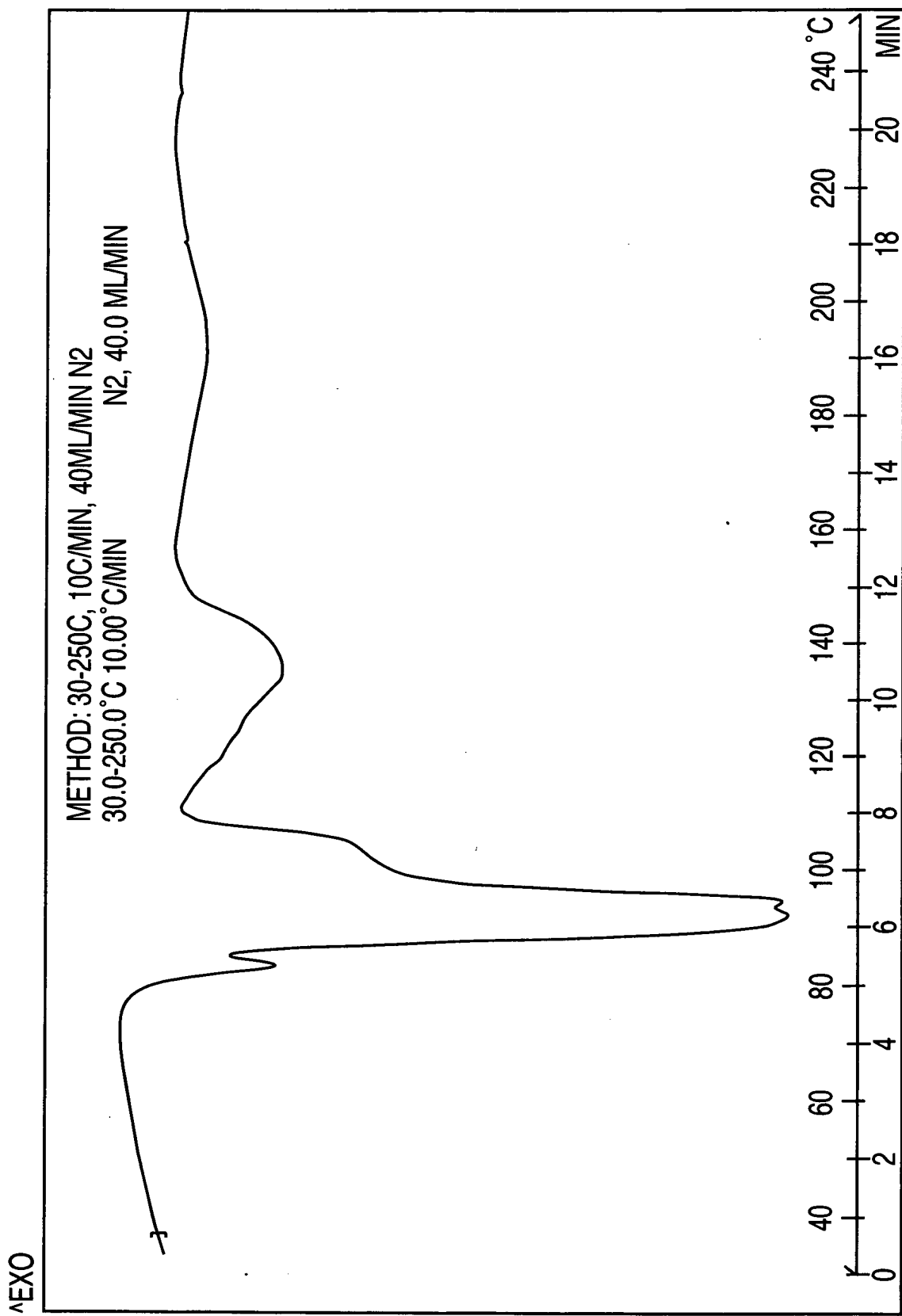


FIG. 59



METTLER TOLEDO STAR^e SYSTEM

FORM GAMMA

FIG. 60

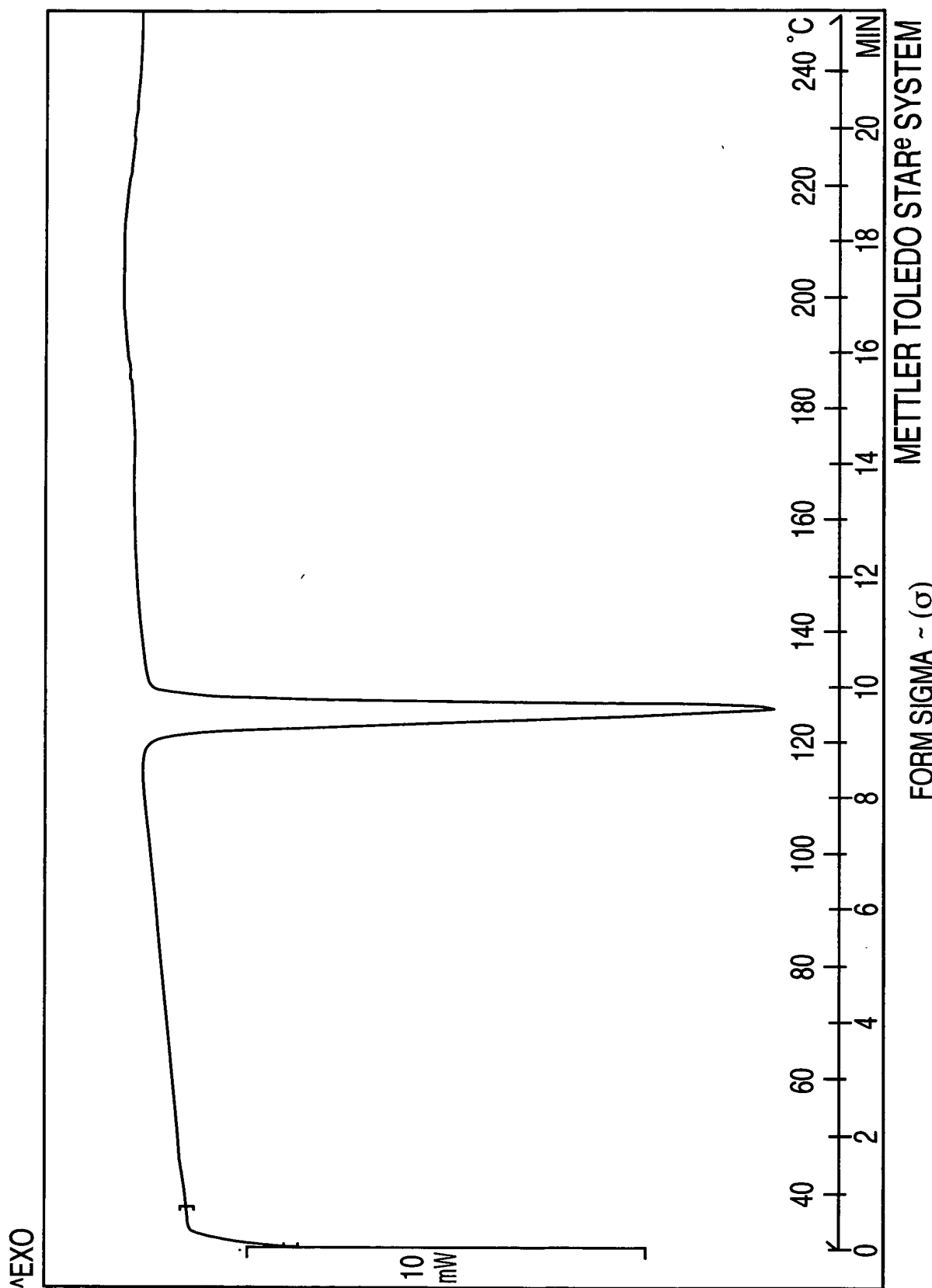


FIG. 61

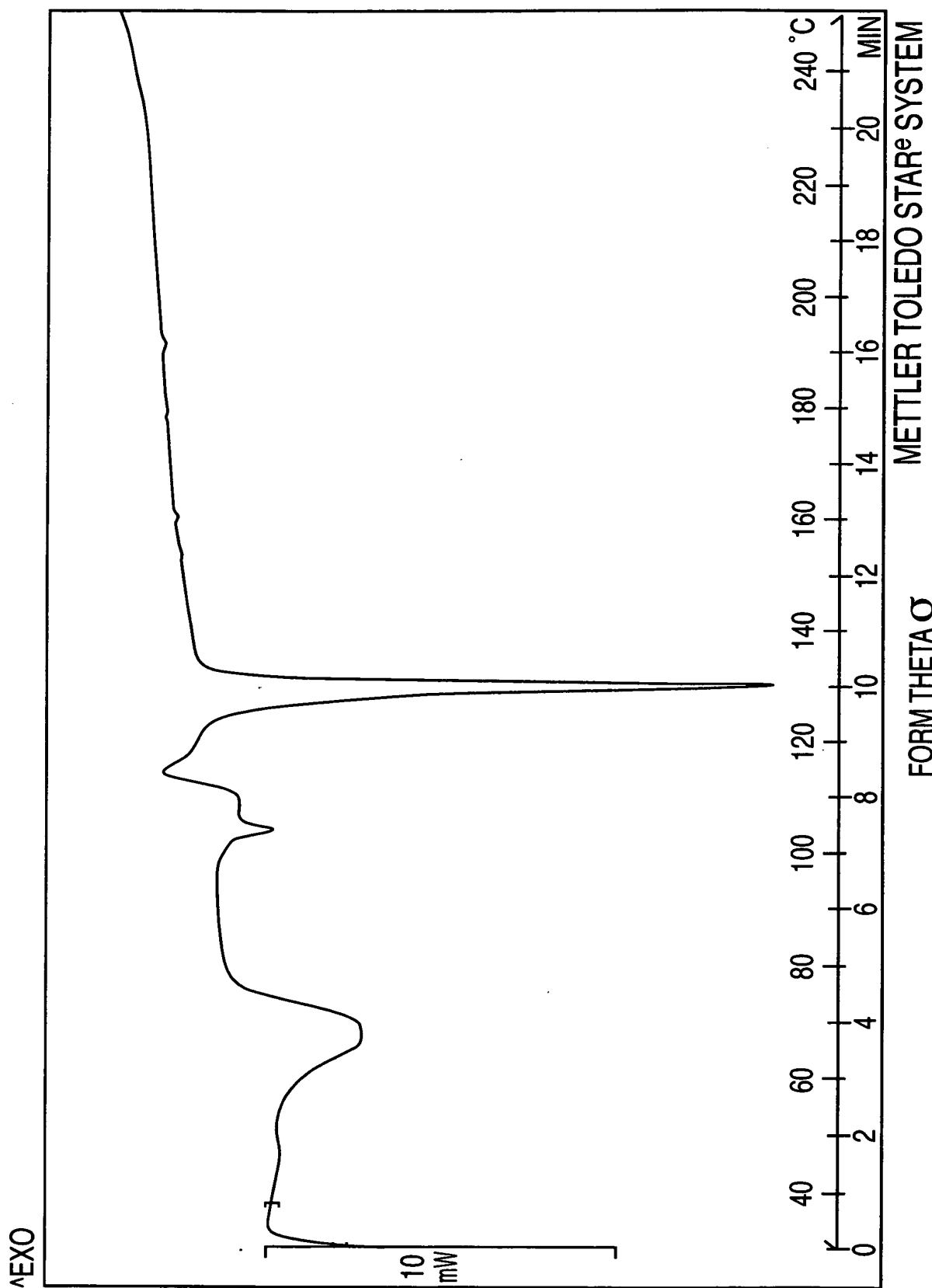


FIG. 62

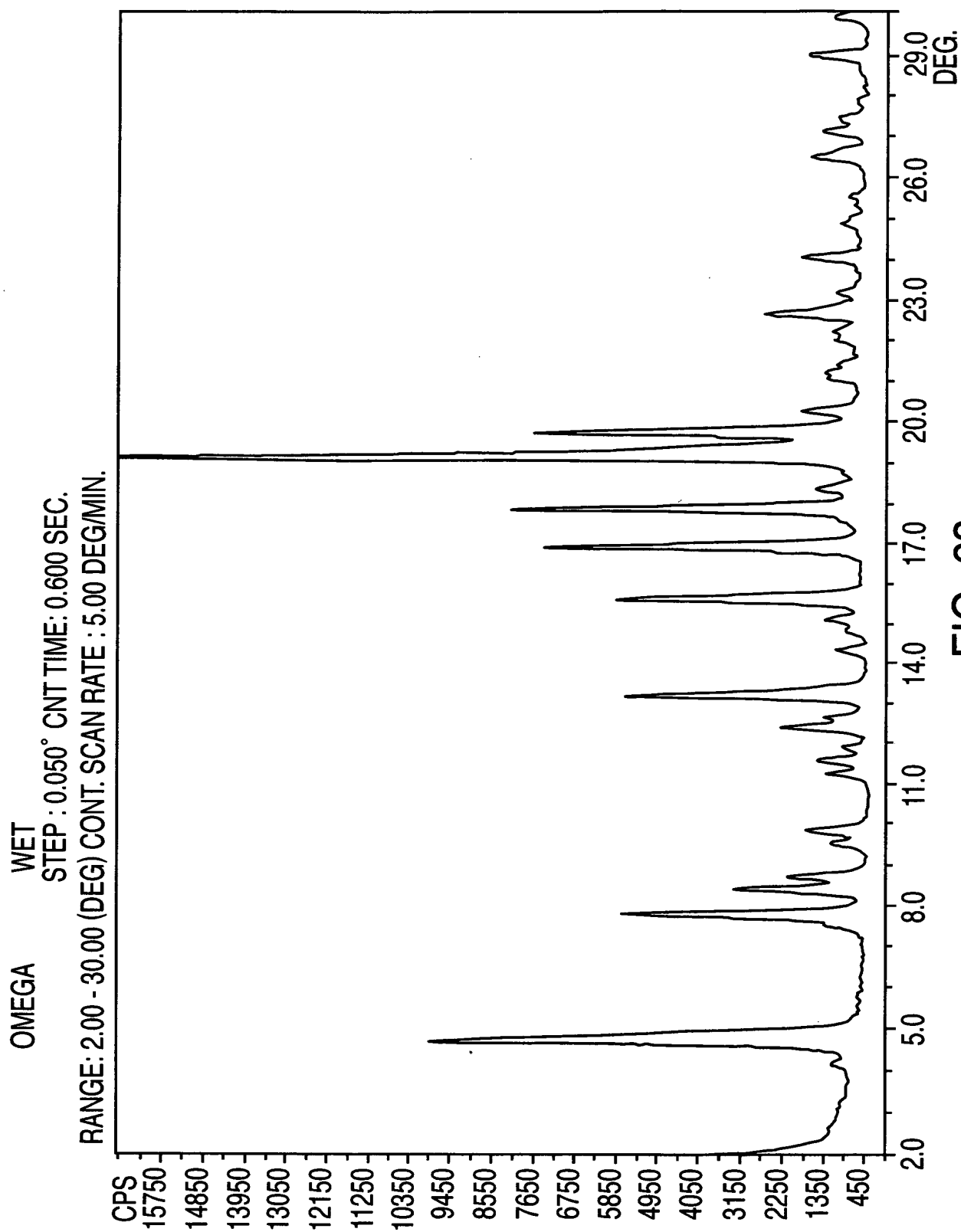


FIG. 63

Comparison between the impurity profile of Nateglinide crystallized in IPA-H₂O and Nateglinide in Methanol-H₂O

Sample No	Solvent	Impurity profile by RRT [% w/w]						
		D-PA (0.23)	(0.25)	(0.46)	(0.80)	Ipcha (0.89)	Dimer (1.38)	Methyl Ester (1.51)
RL-2155/1	Methanol-H ₂ O	<0.01		0.02	<0.01	0.03	0.02	2.91
RL-2163/4	IPA-H ₂ O	<0.01	0.04		0.02	0.02	0.01	
								0.04
								0.03
								0.02

Note: D-PA means D-Phenyl Alanine
Ipcha means Iso propyl cyclohexyl carboxylic acid
Both are the starting materials of the product
(-)-N-[(trans-4-isopropyl cyclohexane)carbonyl]-D-phenylalanine

FIG. 64